

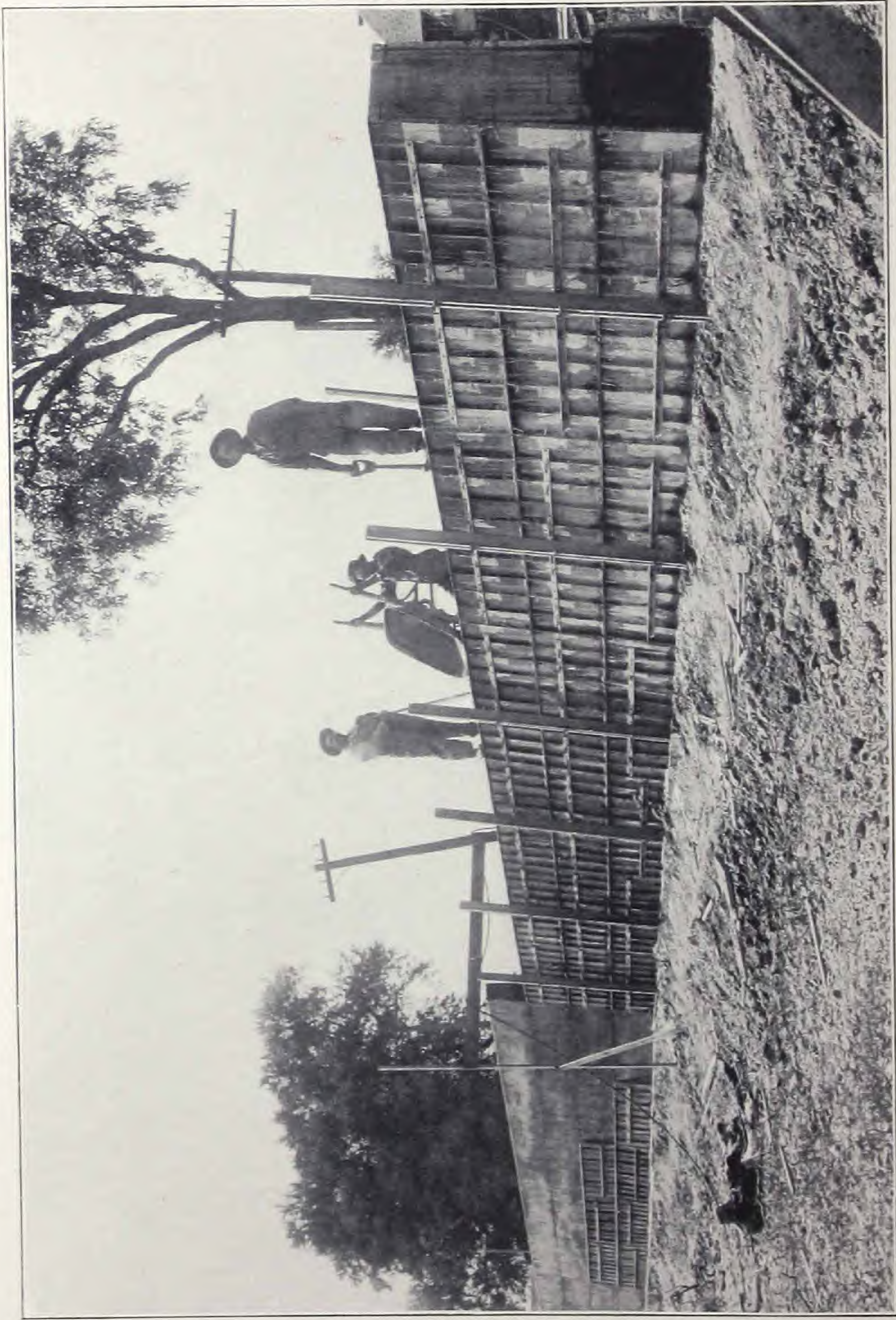
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Bulletin 66

OCT 3 1915
April, 1915



Blaw Light Wall Forms



Blaw Light Wall Forms in use by Ben. F. Walters, Peoria, Illinois, on battered walls six and eight feet high. Three courses are shown set up and receiving concrete. Wire wall ties used on this work.

Blaw Steel Construction Company

General Offices, PITTSBURGH

New York Office
165 BROADWAY

Works
HOBOKEN, PA.

Chicago Office
PEOPLES GAS BLDG.

DESIGNERS AND BUILDERS OF STEEL FORMS
FOR EVERY TYPE OF CONCRETE CONSTRUCTION

Blawforms on over 10,000 Contracts tells the story

THIS bulletin is for the purpose of describing to the contractor Blaw Light Wall Forms. We show merely a few out of the many contracts on which these forms have been used. Blaw Light Wall Forms are being used by the most progressive contractors everywhere. They are suitable for contractors who handle large and important undertakings, and also for contractors who specialize in the smaller type of construction work.

With Blaw Light Wall Forms, the Contractor is able to do better work, with greater rapidity, and less labor cost. These forms are both leased and sold.

During the past 10 years, we have devoted all our time and skill in the designing and manufacturing of money and labor saving steel forms. We are without doubt the leader in this broad field of concrete construction. In every recommendation is embodied the best engineering skill obtainable, made doubly efficient by the constant working out of thousands of problems similar to yours.

We design and build forms for every kind of concrete construction, (see the last page of this bulletin,) and are glad to have an opportunity to furnish estimates for forms on work of any kind. The attention of **Builders** is invited especially to **Blaw column molds** and **floor forms**, besides the **wall forms** described herein.

Consult us about your concrete work. We may be able to save you money on the job you now have, or enable you to bid lower on the one you are now figuring. The services of our Engineering Department are available to you without charge.

How Blaw Steel Forms Save Money.

Labor and lumber are expensive, and are increasing in price. Steel forms attack the high cost of labor by reducing the amount of it required, as well as the amount of skill required in such labor as is employed. They eliminate the cost of lumber.

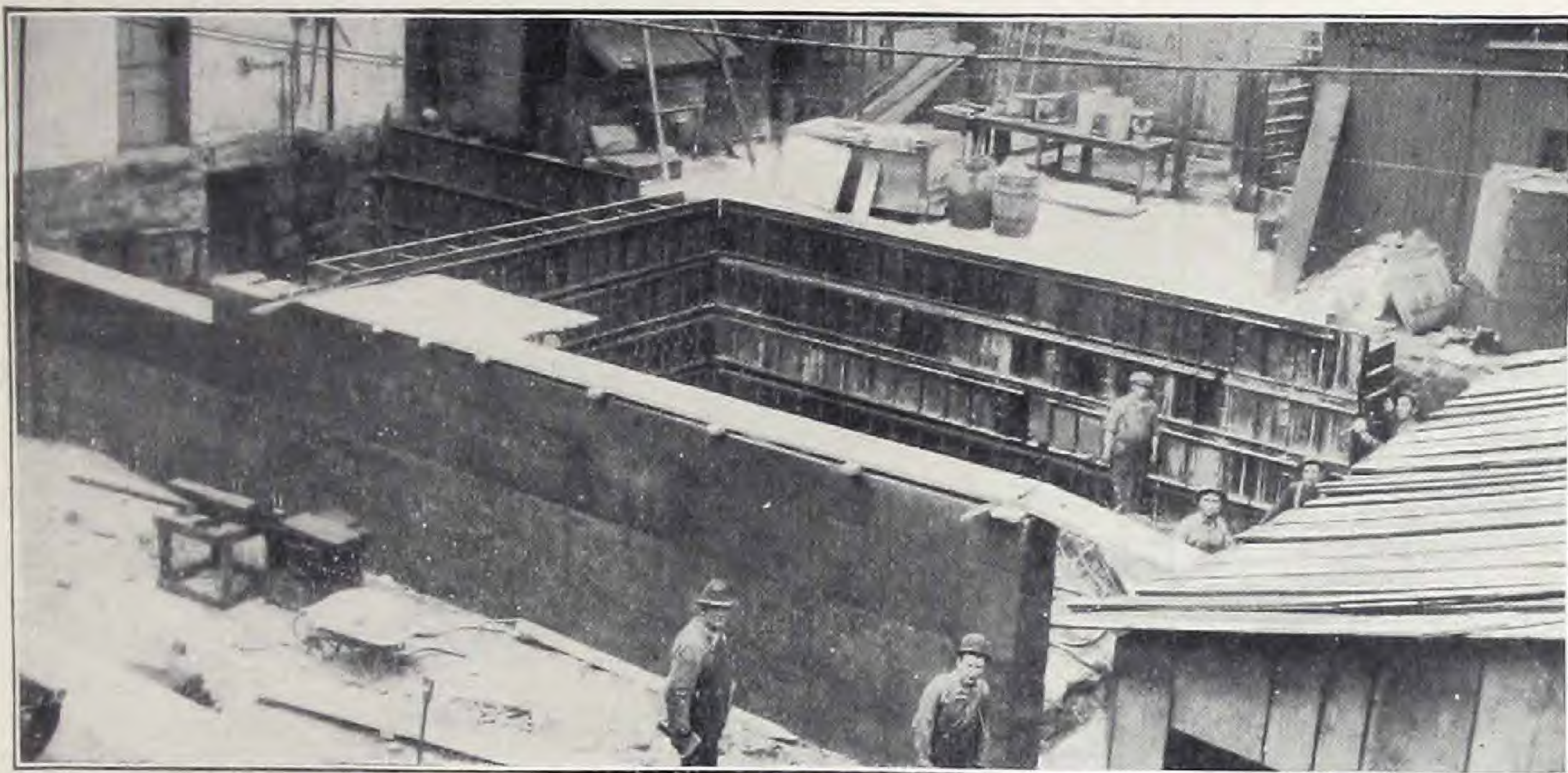
Steel forms, unlike wood forms, do not shrink, warp, crack, leak, or wear out in use. They can be employed over and over again for years. They present smooth surfaces to the concrete, require much less oil than wood, can be handled very much more rapidly, and can be used on all kinds of work.

Where to Use Blaw Light Wall Forms.

For very heavy walls where the forms may be shifted on tracks or carriers, or by means of a moving derrick, we furnish Blaw Standard Lagging or Blaw Combination Lagging. Write us if you have any such heavy work to perform. Blaw Light Wall Forms are especially adapted for the walls of concrete buildings, foundations, retaining walls, and other structures where the forms are set up and shifted by hand.



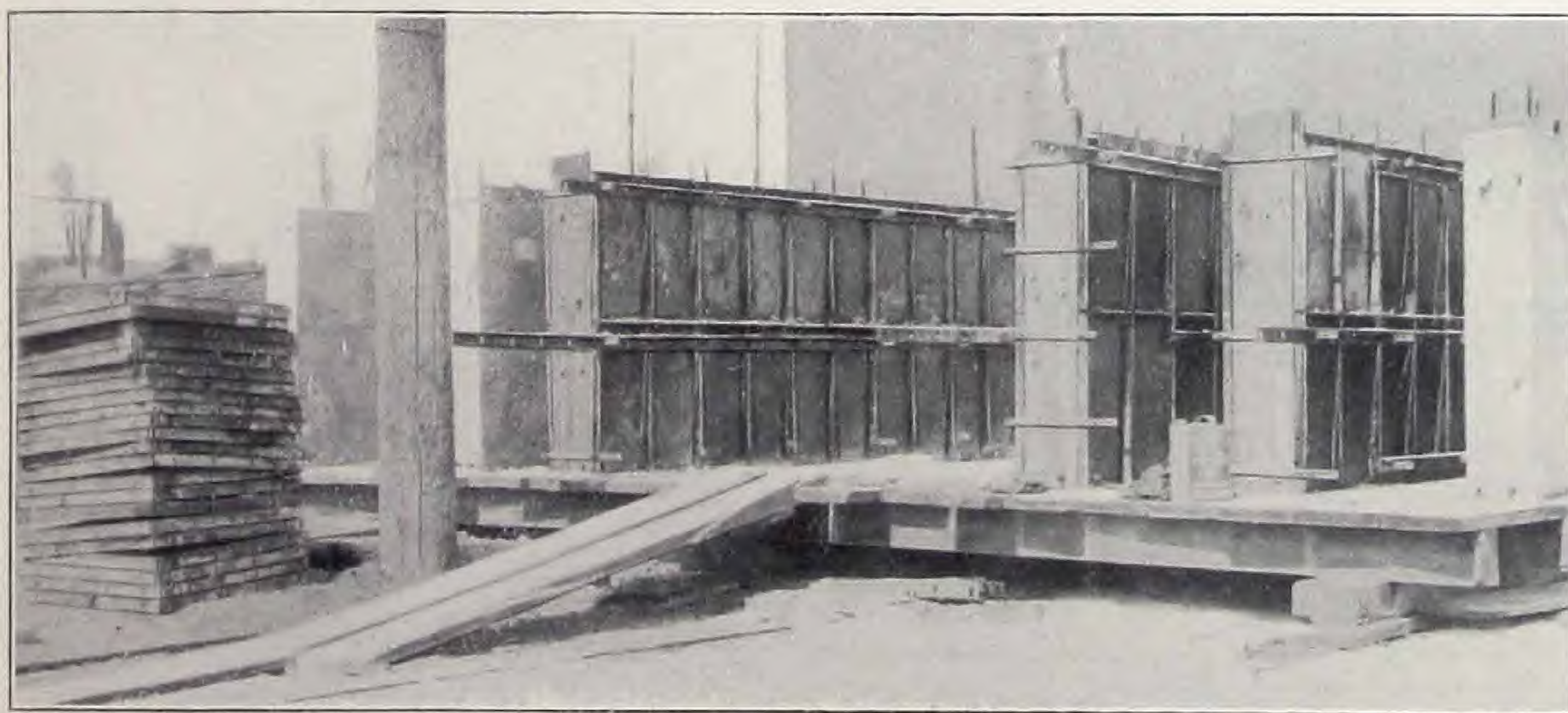
Blaw Light Wall Forms on House Foundations. H. E. Putnam, Hartford, Conn.



Blaw Steel Wall Forms in use by Geo. M. Bock & Son, Coshocton, O. This view shows forms 8 feet high with horizontal liners 2 feet apart, in the usual manner. Finished wall in foreground.

Description of Blaw Light Wall Forms.

On work of this kind it is necessary, for purposes of transportation and adjustment, that the unit of form surface be small. Our standard light wall form panel is two feet square, flanged on four sides, and is light and easily handled. Panels of other dimensions are furnished to facilitate adjustment to any dimensions required. Besides the panels, there are liners, spacers, and fasteners.



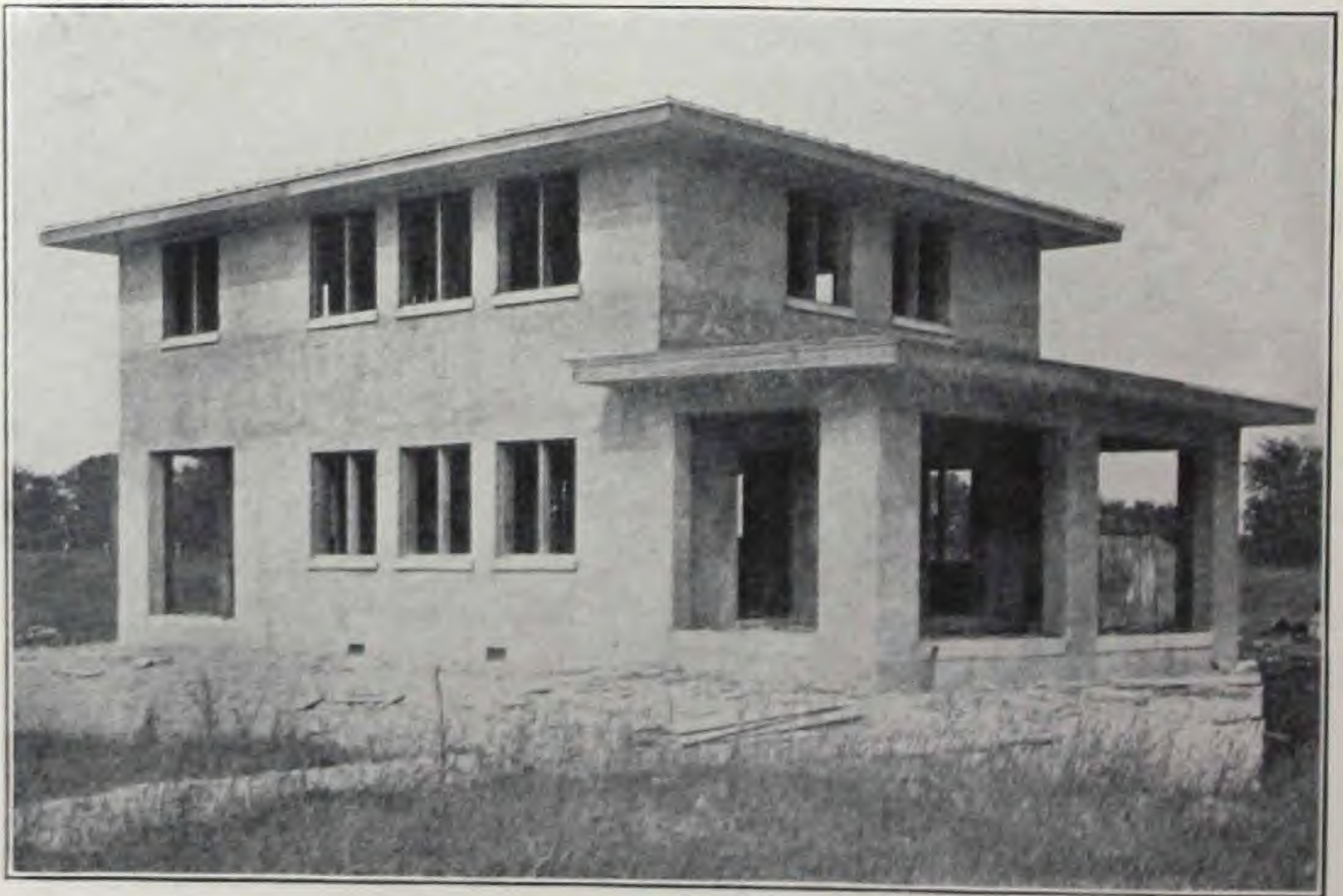
Blaw Steel Wall Forms in Use by C. H. Diefendorf, Erie, Pa., to Cast Large Reinforced Concrete Beams on a Casting Platform. The Beams Were Subsequently Erected by Derrick on Work of Improving the Canal Basin at Erie, Pa. Shows Wide Application of Blaw Light Wall Forms.

Some Features of Blaw Light Wall Forms which make them the most widely used forms on the Market

Durability—Blaw Light Wall Forms are built entirely of steel,—there is no lumber attached to warp, swell or go to pieces. The panels themselves are extremely strong and durable. They are reinforced with angles $7/8"$ \times $1\frac{3}{8}"$, which are stiffer than the angles used on other forms, and will stand greater strains. Consequently, Blaw forms may be set up for a greater height of wall and filled more rapidly than others.

No Loose Clamps—There are attached to the panels themselves no projecting clamps liable to be knocked off in use, or to become loosened by accidental dropping of a tool while concrete is being poured.

Fasteners Secure—The fasteners used for joining panels together, for attaching liners, and securing spacers or ties, are all exactly alike, easily secured and removed by a blow of the hammer. When placed, these fasteners stay placed until intentionally removed by the workmen.



Low Cost Concrete House Built with Blaw Light Wall Forms.

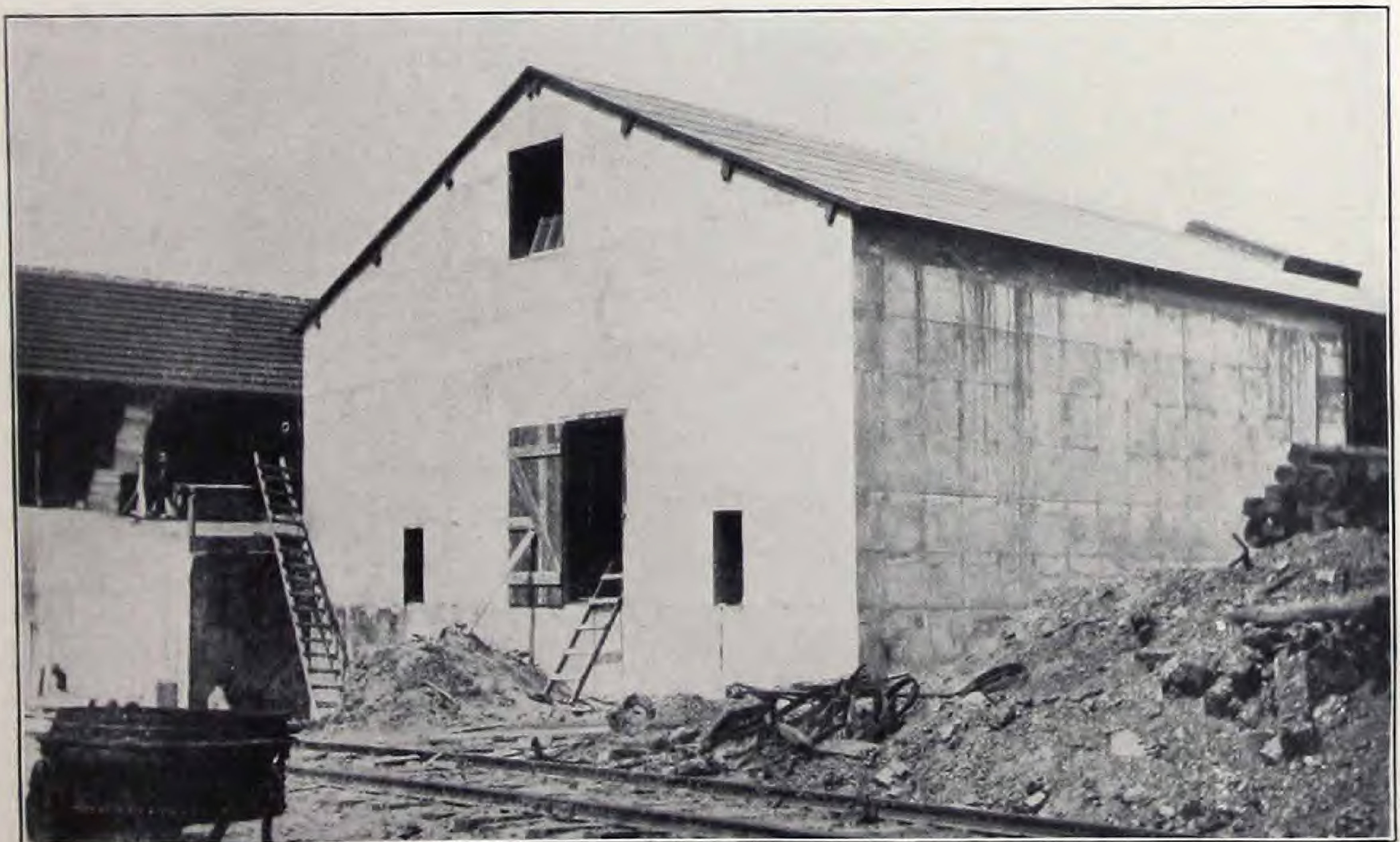
Horizontal Liners—Blaw Light Wall Forms are provided with steel horizontal liners in every instance, making the lining up of Blawforms more accurately and quickly accomplished than the lining up of any other type of wood or steel mold.

Shifted in Large Units—The horizontal liners, being left attached to the panels, Blaw Light Wall Forms are ordinarily shifted in units of 20 to 30 sq. ft. instead of the smaller units commonly employed with other types. This saving in time and labor is a very big item, especially on large jobs.

Vertical Liners—By means of vertical liners, the form is lined up ready to receive concrete for a height as great as may be desired. It is not limited to two course working, but may be employed according to that method, or any other that the contractor may elect.

Uniform Wire Ties—When wire ties are employed with Blaw Light Wall Forms, the ties are made up on a frame furnished for that purpose, before the form is set up. Thus the ties are made much more cheaply, and of exactly the same length and strength, insuring perfect uniformity of wall thickness.

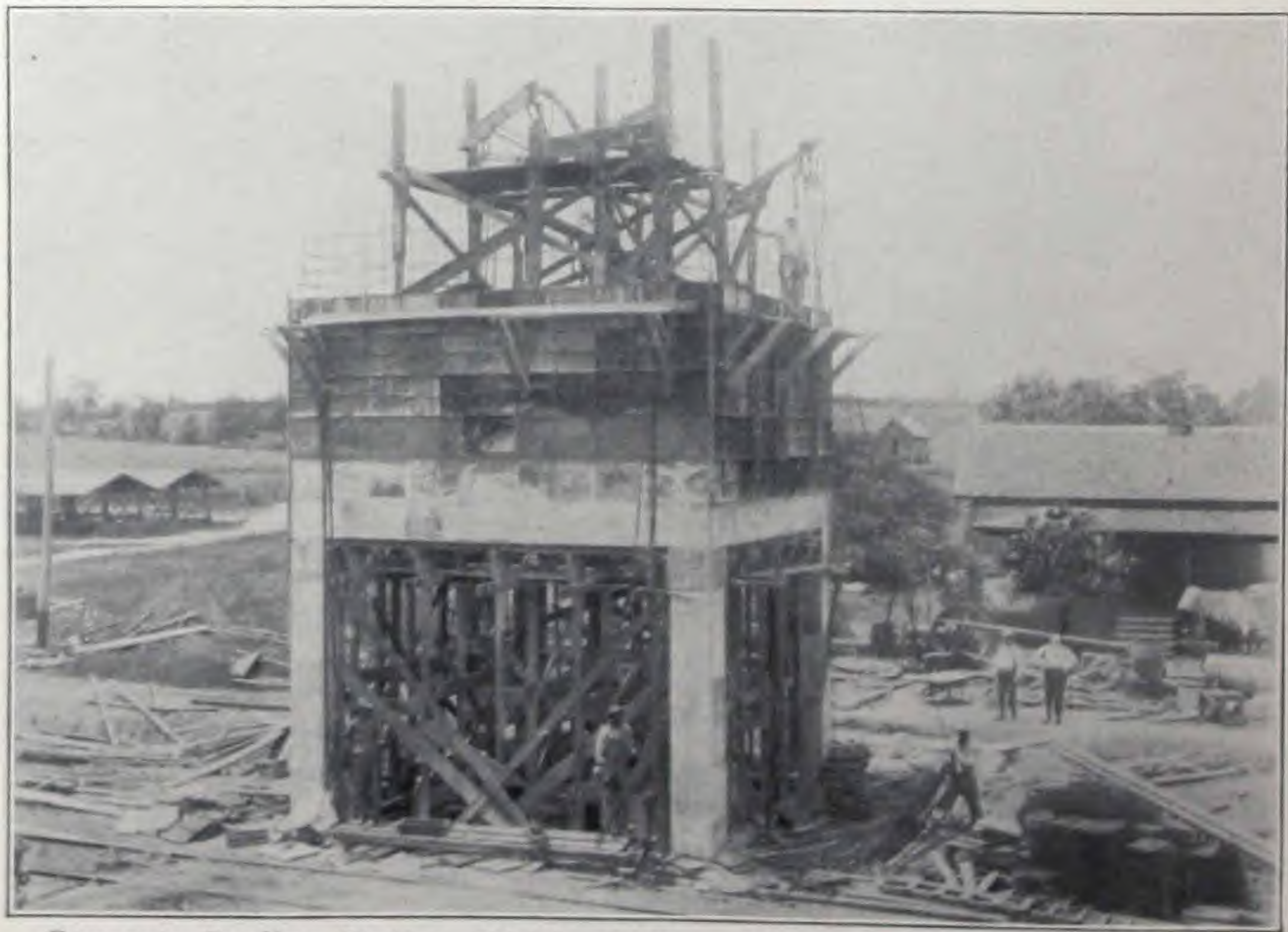
Removable Spacers—For walls of buildings, our removable spacers take the place of ties; and their use results in still further economy of construction and perfection of alignment.



Concrete Storage House Built with Blaw Light Wall Forms.
Union Stock Yards, Chicago, Ill.

Standard Corner Connections—For houses and other buildings, Blaw Light Wall Forms are provided with standard corner connections, adjustable and adaptable for walls of any thickness and length, and useful in constructing chimneys. These devices do not interfere in any way with the regular system of spacers or ties, or with the use of the liners. An equipment for one foundation job may be used on any other, as it is made up entirely of standard parts.

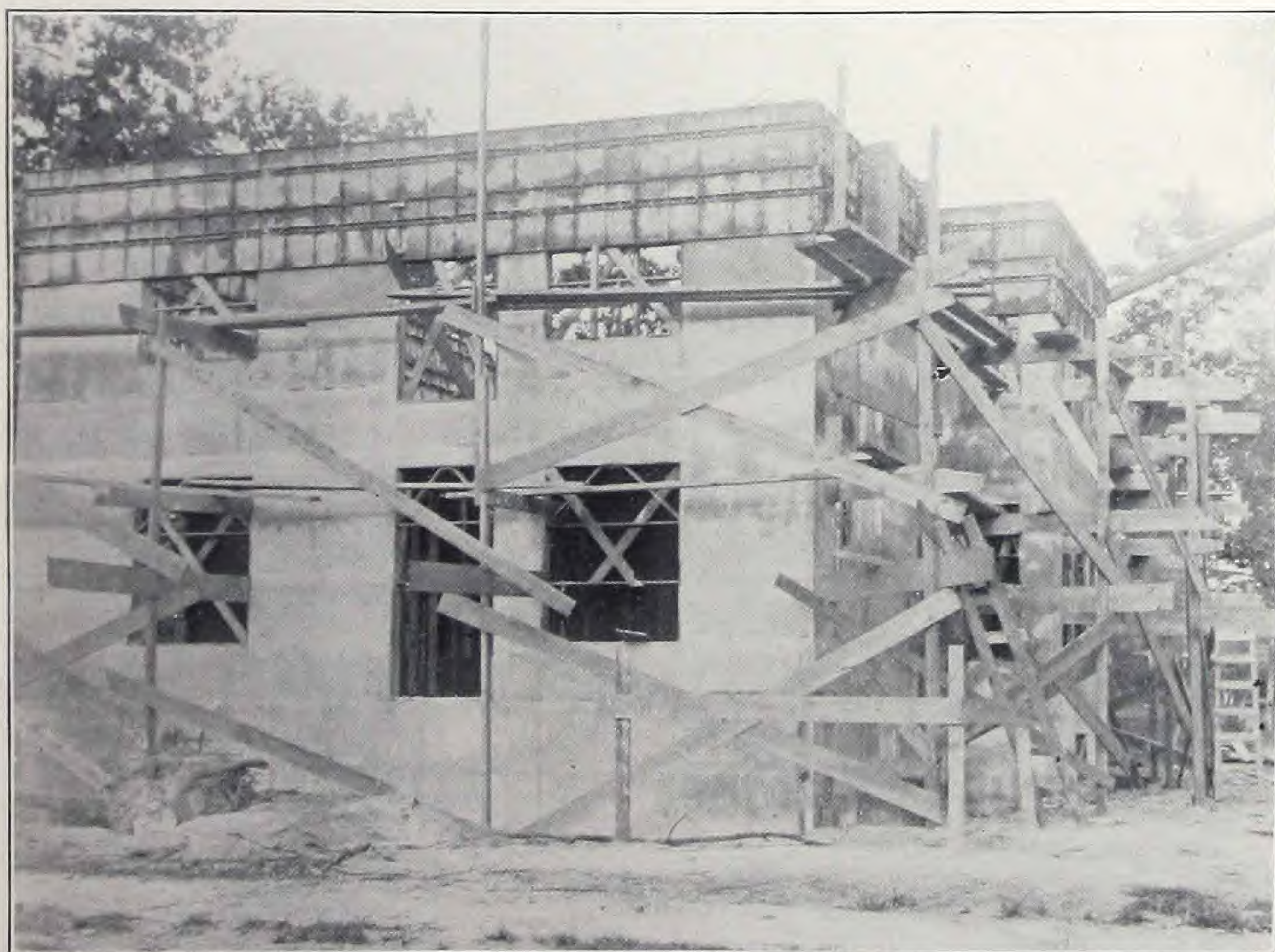
For Large or Small Jobs—Blaw Light Wall Forms are equally well adapted for large or small jobs. Other forms are more limited in their scope; either requiring that the concrete be deposited too slowly (as to depth) to suit the convenience of the contractor, making too many operations and consuming too much time to complete the work at each point, so as to be unsuitable for large work; or, on the other hand, demanding a method of handling that is correspondingly undesirable on a small job because it demands too much equipment. Blaw Forms may be used to pour concrete two feet deep at an operation, or ten feet deep at an operation, with equal facility, employing the most economical methods in both instances.



Concrete Coaling Station, Richland, Ga. Fairbanks-Morse Co., Chicago.
Three Courses of Blaw Light Wall Forms Used.

Efficient Engineering Service—The Blaw Steel Construction Company offers its customers the services of a corps of experts in form design and handling. On large jobs, while employing standard forms and principles of design (protected by our many patents), we lay out the equipment so as to secure every possible advantage to the contractor in the matter of economy on the special job which he has in hand at the time. Blawforms have been used on over 10,000 contracts which take in many of the largest and most important contracts on record.

Blaw Forms Either Purchased or Leased—Blaw Light Wall Forms may be either purchased or leased. For miscellaneous work, such as foundation construction, or for house building, it is better to purchase a suitable outfit of moderate size. This may be increased if the business increases; and the builder by using the same equipment for several jobs in succession does his work very cheaply indeed. On very large jobs, requiring an equipment greater than the contractor can keep busy on ordinary work, it is better for him to lease the forms for the job.



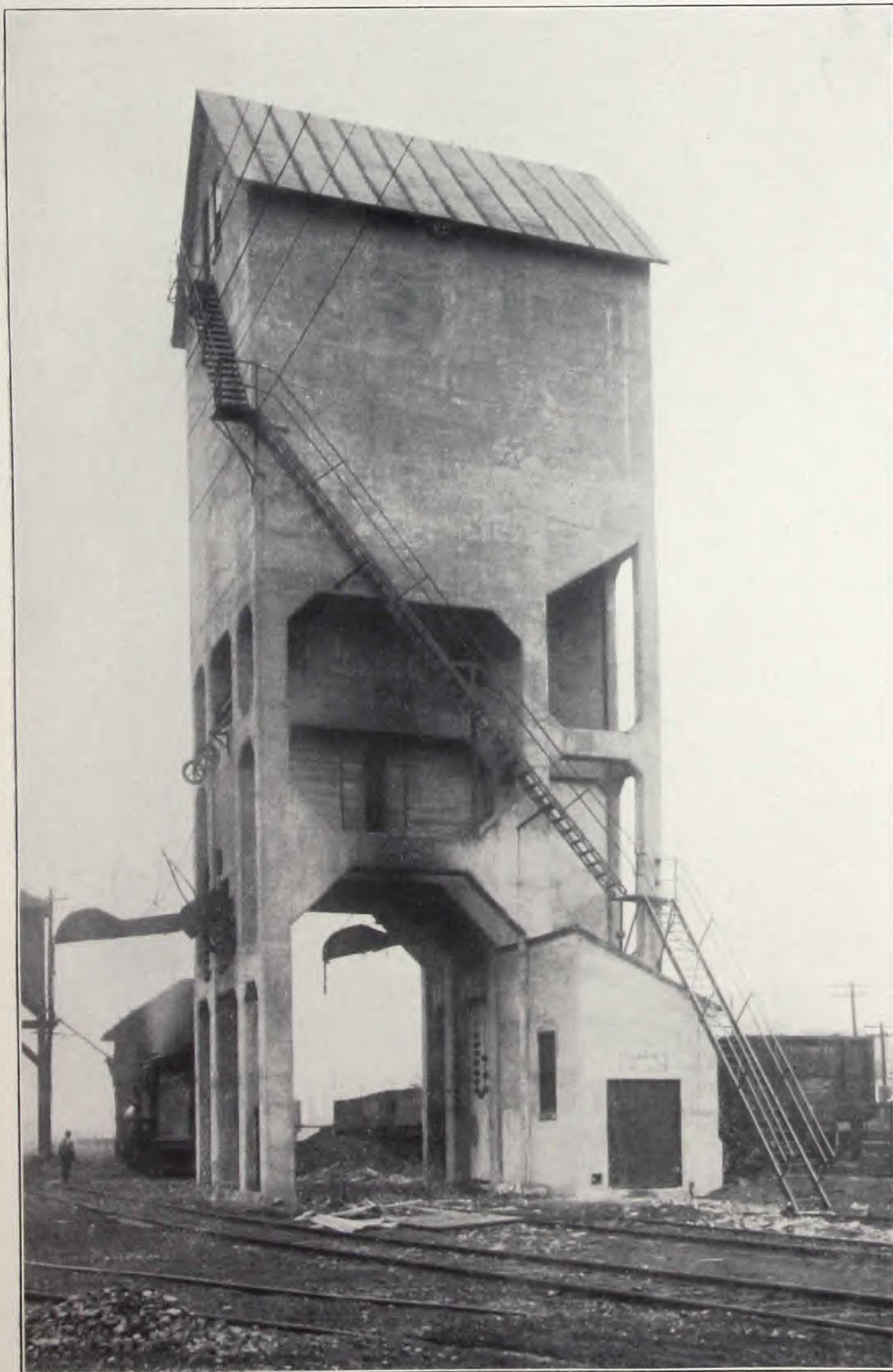
Blaw Light Wall Forms in use on Concrete House. Two course method used. Note Perfection of Alignment and Finished Surface.
Constructed by H. A. Clapp, Springfield, Mass.

Summary of the Advantages of Blaw Light Wall Forms.

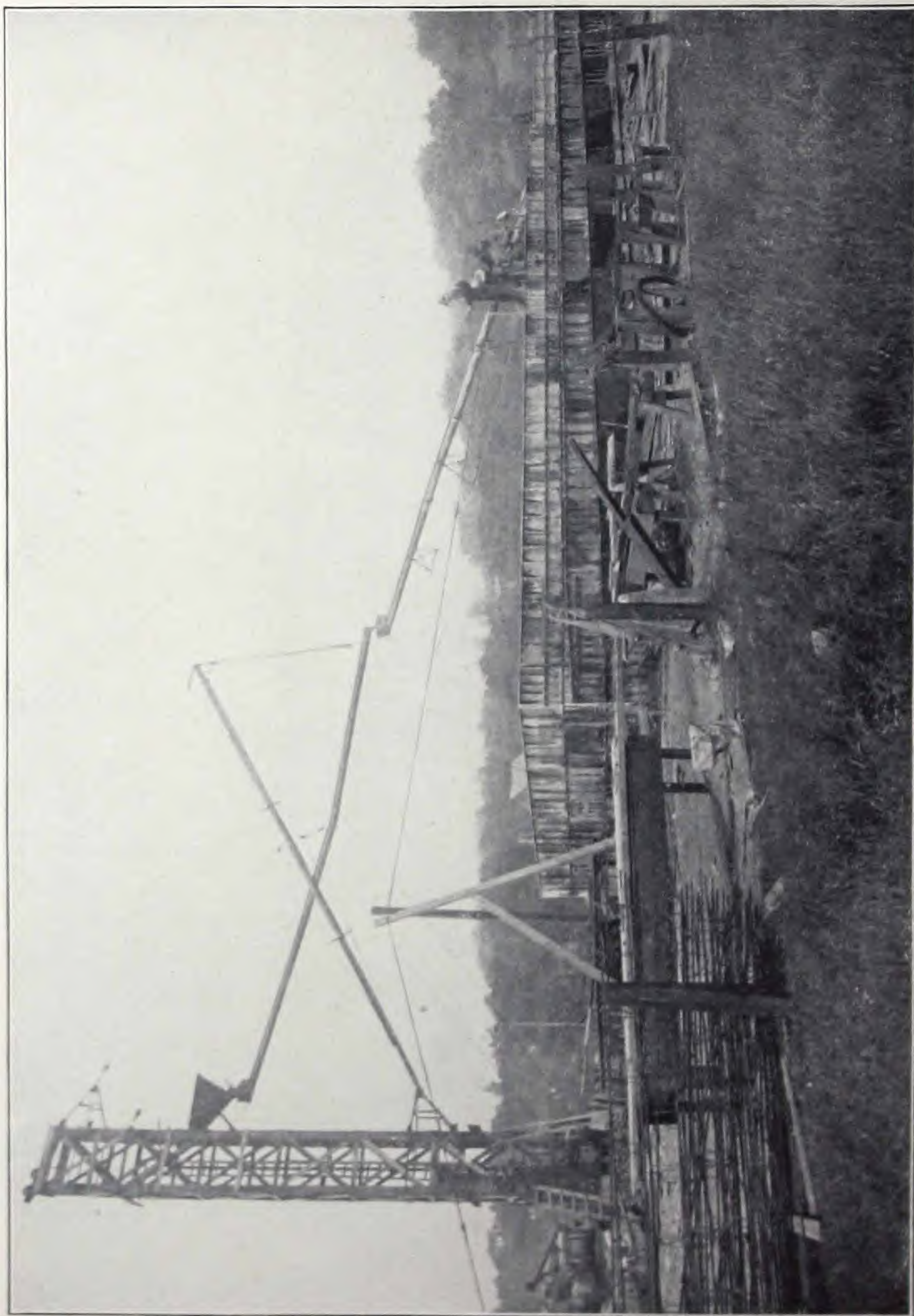
The illustrations in this bulletin have been selected to show the wide range of adaptability of Blaw Light Wall Forms, by picturing some of the structures on which they have been used. They eliminate all waste of material, produce perfect walls, and cost less to handle than any other forms. The work involved in handling them on ordinary walls is, on the average, including lining up, bracing, removing, oiling, and all expense connected with the form work, about half that of wood forms; and skilled labor, except to direct the work, is not necessary. They are profitable equipment for any person having concrete walls to build. As they are set up and shifted much more rapidly than wood forms, a smaller outfit of steel forms than of wood forms will do the same work in less time. Call upon us to prove that they will save you money on the particular kind of work in which you are now interested.



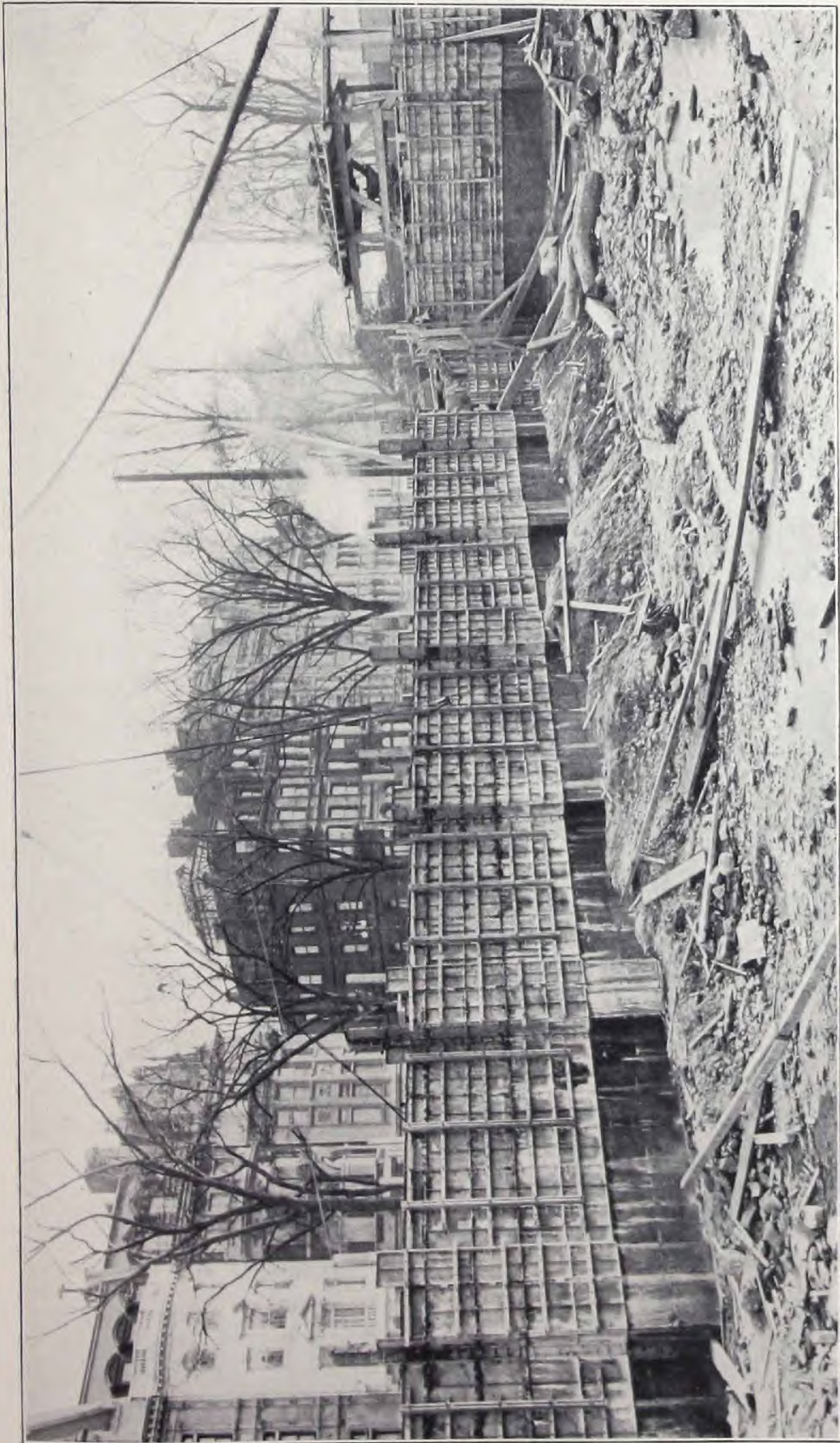
Blaw Light Wall Forms on Retaining Wall, ten feet high, Plant of Hubbard & Co., Pittsburgh, Pa. Pihl & Miller, Contractors. Form set up for full height before pouring concrete.



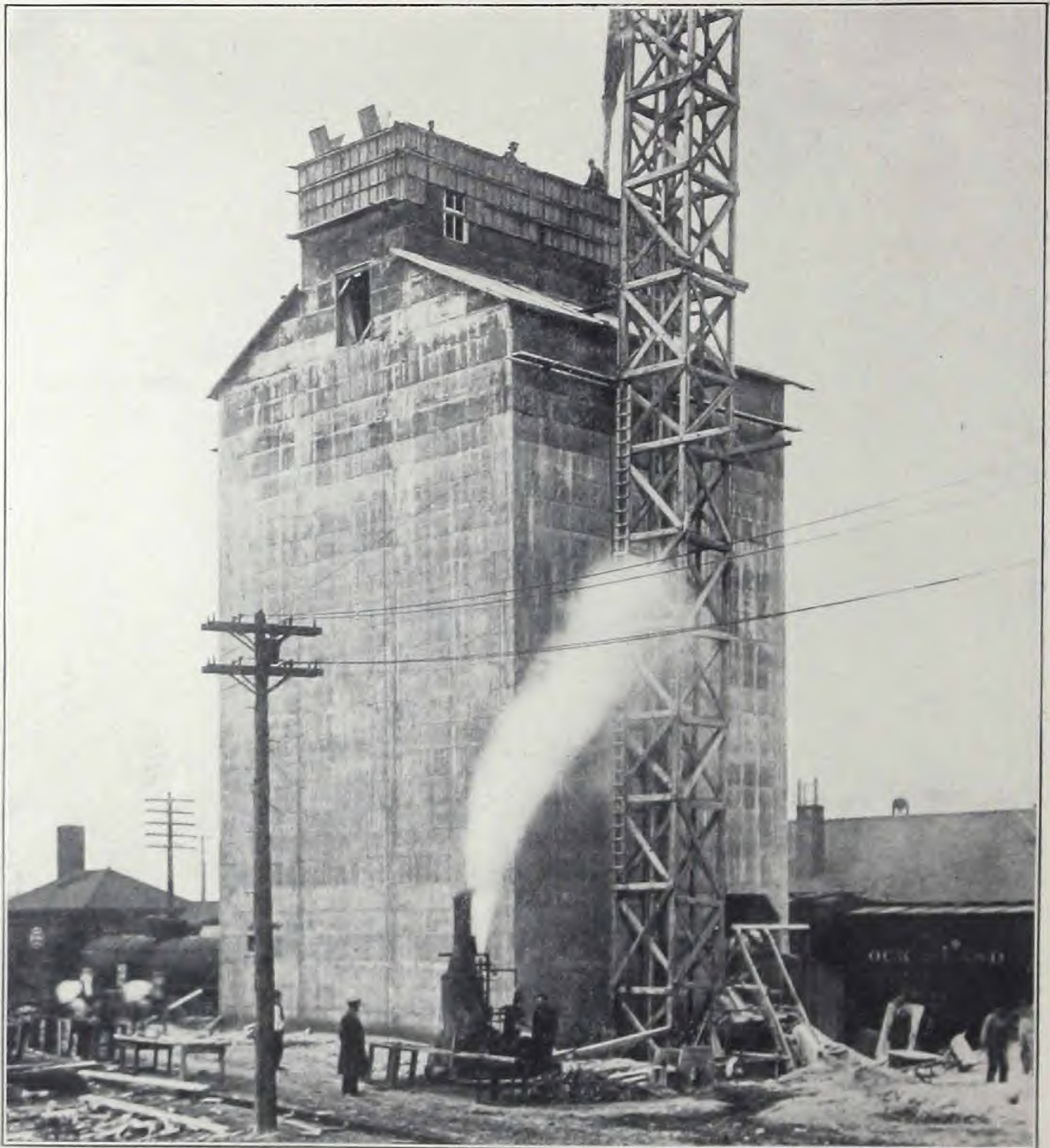
Railroad Coaling Station built with Blaw Light Wall Forms by Fairbanks, Morse & Co., Chicago. Many similar stations have been built by this firm, using the same equipment of Blaw Forms.



Blaw Light Wall Forms Being Used on Foundation and Wall Construction.
Harper Lumber and Building Co., Meadville, Pa., Contractors.
Two Course Method Being Followed.



Blaw Light Wall Forms in use on Foundations for Fine Arts
Museum, New York City. P. F. Kenny Co., Contractors.
Four courses of Panels in use.



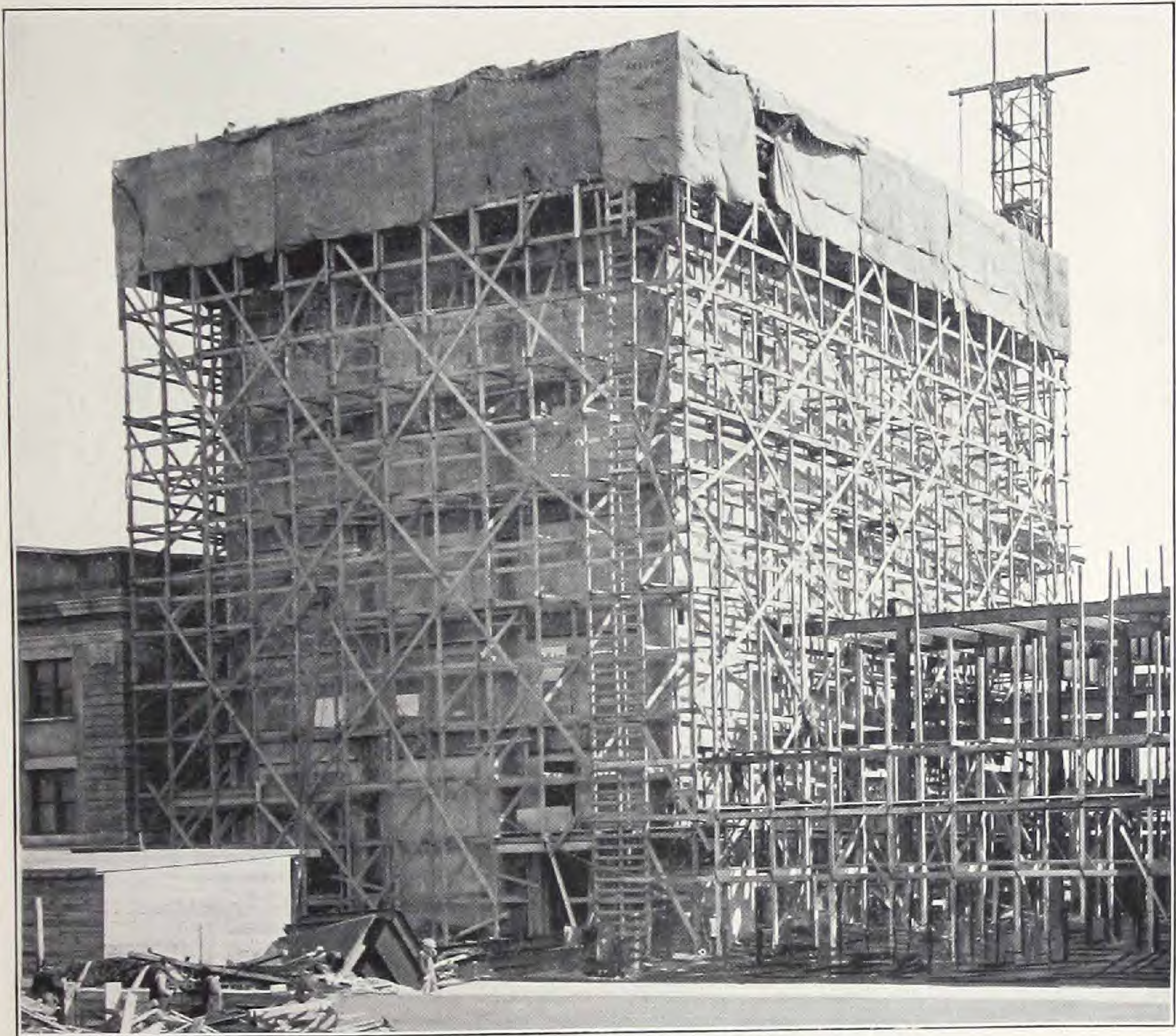
Square Bin Concrete Elevator at Morris, Illinois, erected by the Younglove Construction Co., of Sioux City, Iowa. Blaw Light Wall Forms used.

The experience of the contractors who built the Concrete Elevator pictured above is conclusive proof of the superiority of Blaw Steel Forms over Wood Forms. As the following letter shows, they appreciate Blaw Form efficiency and economy.

"We used your forms on a square bin concrete elevator at Morris, Illinois, and after having some special forms made for the corners and angles, we made **very** satisfactory progress. The process was perfectly satisfactory and the walls were smooth and plumb. Using the liners, as you have planned and made them, it is impossible for this to become out of plumb, as the walls are carried up.

This year we erected a square bin grain elevator at Archer, Iowa, about the same design as we built at Morris. I desired to procure one more course of Blawforms using three in place of two courses, but was prevailed upon to use movable forms with wood staves fitted with jack screws. We had trouble with our wood forms from the very start. Had we used Blawforms we would have saved on the labor cost including the forms over \$1,500.00, and would have had a great deal better looking job when completed.

We can assure you, if we continue to build concrete grain elevators, we will use no other system of forms than those made by the Blaw Steel Construction Co."

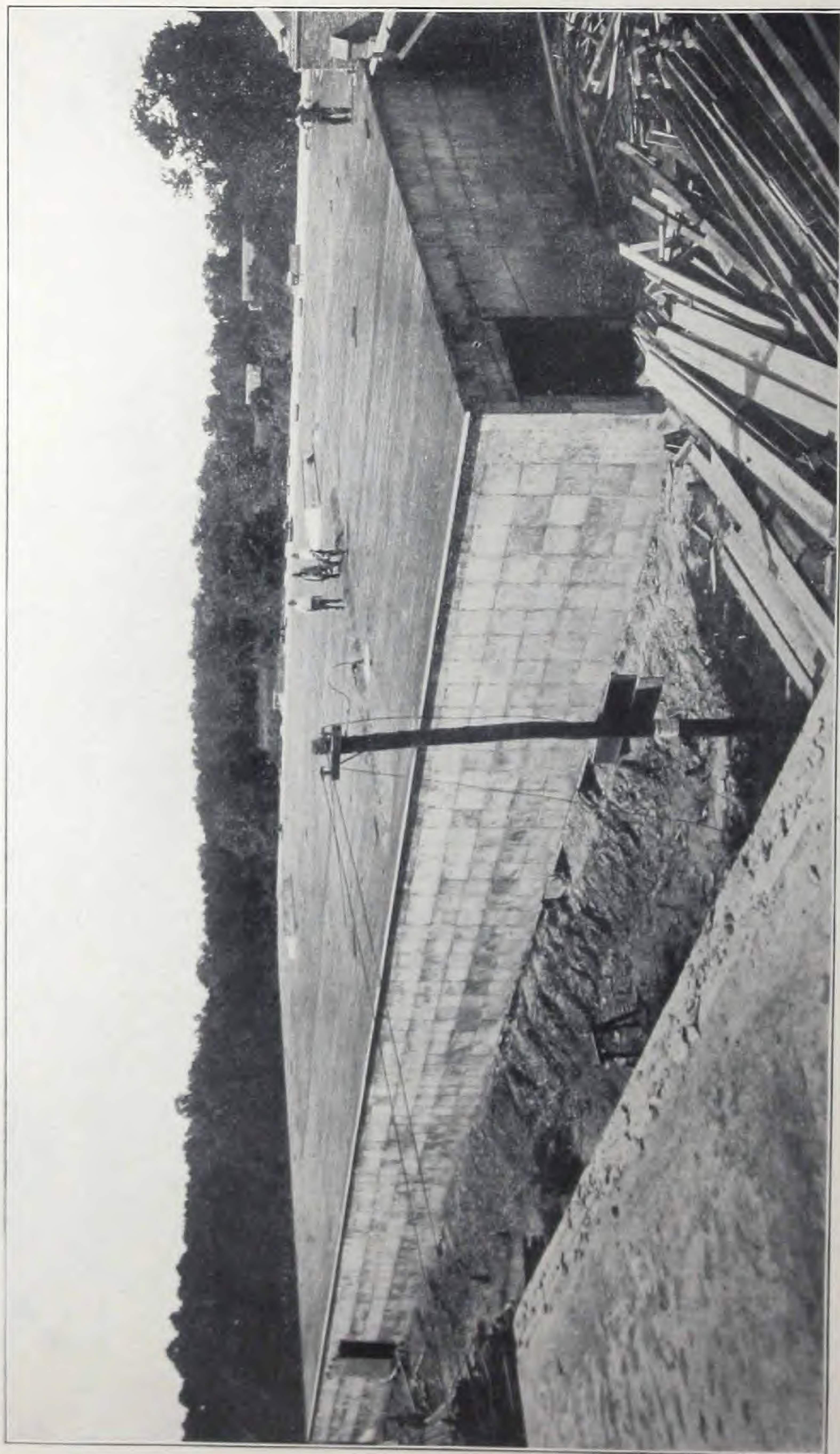


Blaw Light Wall Forms in use on Commonwealth Ice and Cold Storage Co. Buildings at South Boston, Mass. Erected by Aberthaw Construction Co., Boston, Mass.

Cold Storage Plant.

The buildings of the Commonwealth Ice and Cold Storage Company, Boston, Massachusetts, one of which is shown above, are of unusual construction. The outer walls are of concrete four inches thick, with columns and beams at intervals to take care of stresses due to wind pressure. The inside of these walls is insulated from the frame of the building by cork. Blaw Light Wall Forms were used on the outer walls. The building shown on this page was put up in the winter in record time, as follows:

Date started	November 12, 1913.
Completed	December 17, 1913.
Actual number of working days	28.
Average temperature of weather	40°.
Height	70 ft.
Dimensions of plan	56 ft. 6 in. by 70 ft.
Size of panel shifted in one unit	8 ft. by 14 ft.



One of the Cotton Warehouses of the Merchants and Planters Compress and Warehouse Company at Houston, Texas, nearing completion. Blaw Light Wall Forms used. James Stewart & Co., Inc., Contractors, St. Louis, Mo.

Blaw Light Wall Forms in Warehouse Construction.

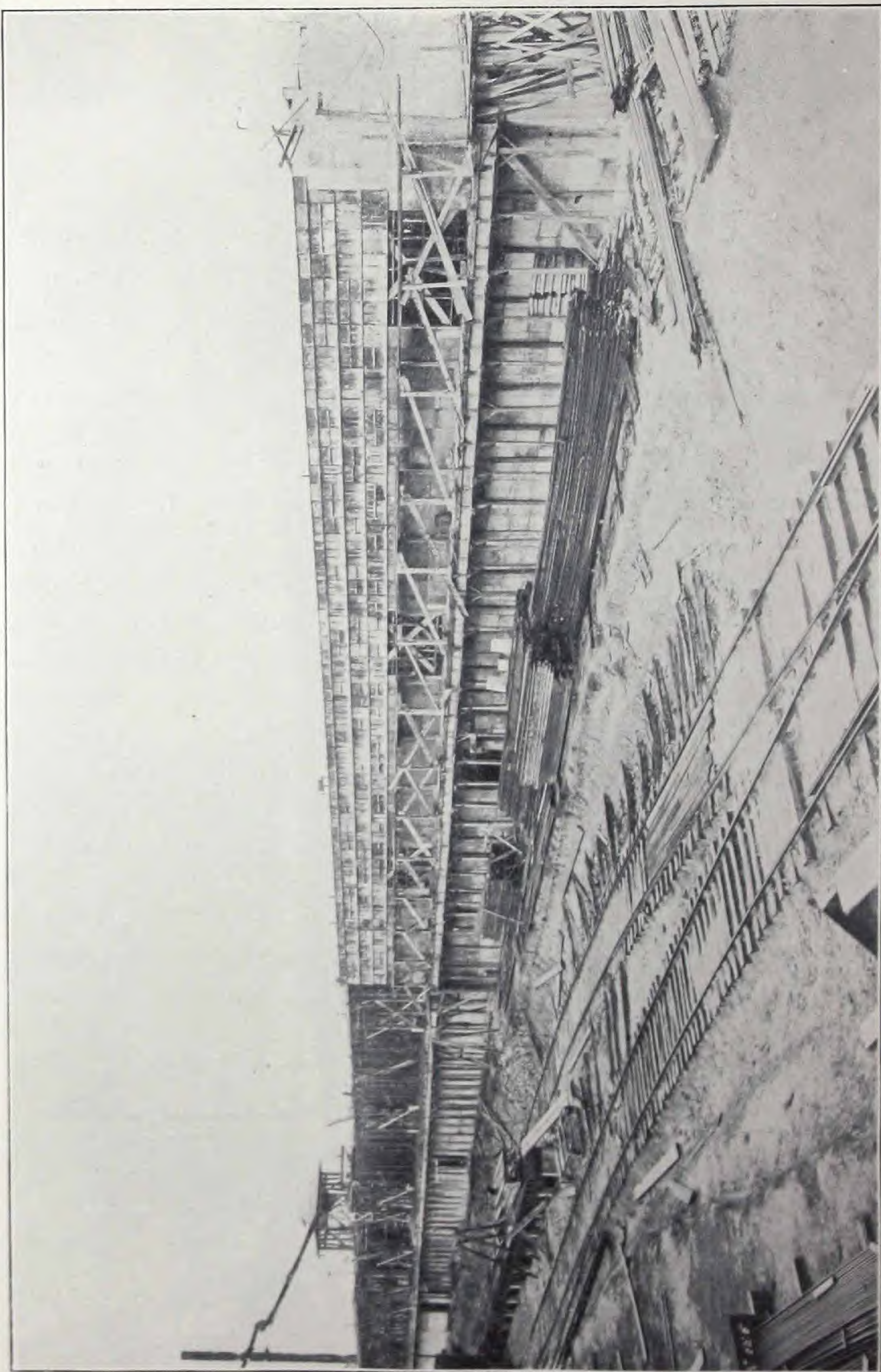
Blaw Light Wall Forms are especially adapted to the construction of fireproof warehouses for the storage of cotton, or other combustible products. On pages 16, 18 and 19 are shown some buildings of this kind constructed by James Stewart & Company, who have had much experience in this kind of work.

The building shown on pages 18 and 19 contains 173,000 sq. ft. of wall surface, and was constructed with 6,900 sq. ft. of Blaw Light Wall Forms, which, to quote from the contractor's letter, "were, therefore, used in this work approximately twenty-five times and were still in good condition. The lifts were from six to eight feet, and in some cases as high as ten feet were poured without any difficulty."

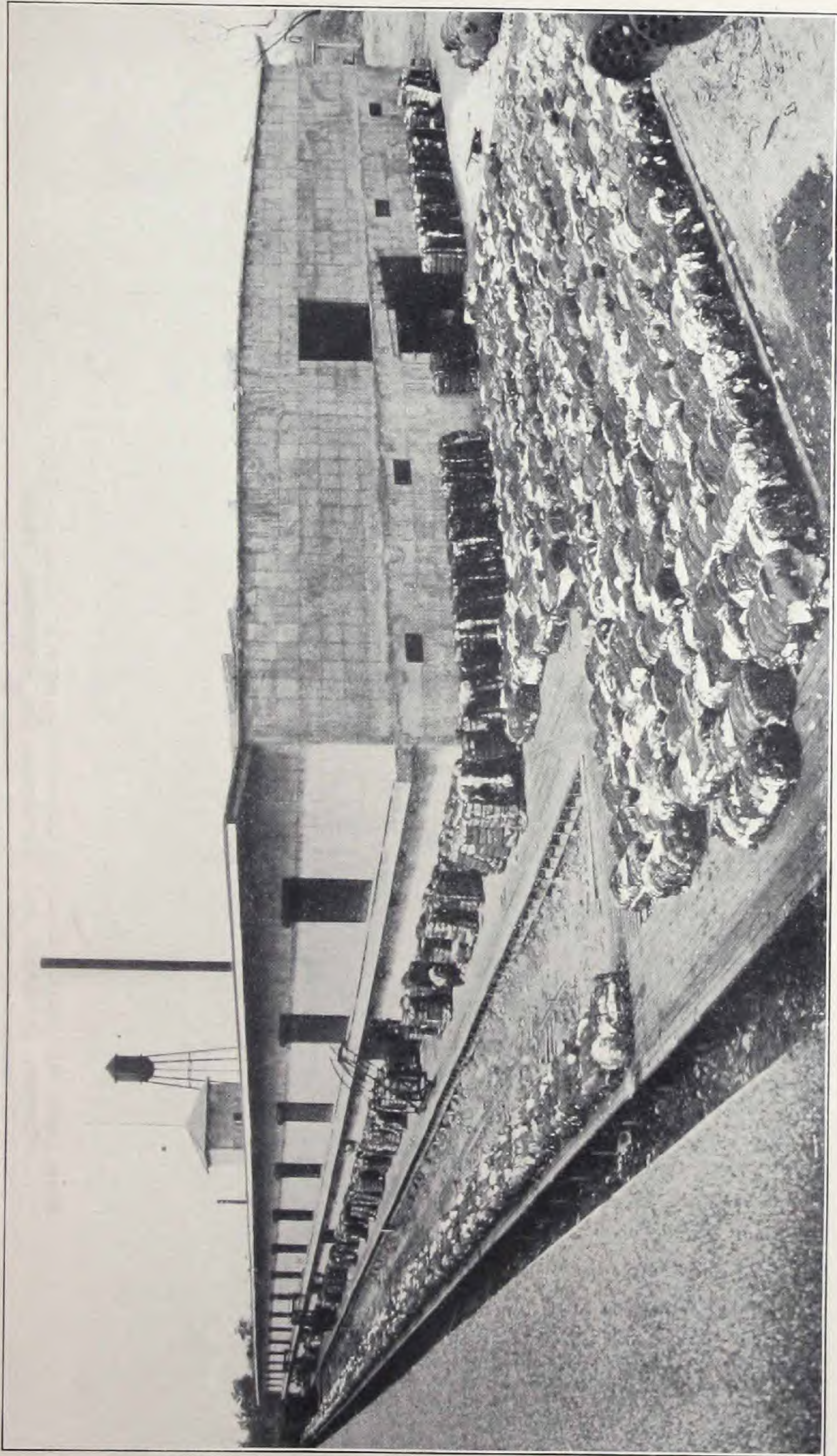
The building is two stories high, 105 ft. wide, by 714 ft. long, and is divided into five compartments on each floor by fire walls 12 inches thick. Actual time of construction was five months.

On Pages 20 and 21 are shown illustrations of cotton warehouses under construction in Galveston, Texas, by the Gilsonite Construction Company. This group of buildings comprises twenty-eight cotton warehouse compartments 80 ft. by 100 ft. in plan, with walls 18 ft. to 22 ft. high, besides compress building and sheds. Cut on Page 20 shows Blaw Light Wall Forms in use on warehouse walls, and cut on Page 21 shows finished side of some of the buildings. These walls were poured in 10 ft. and 12 ft. lifts, usually 260 lineal feet of wall at an operation.

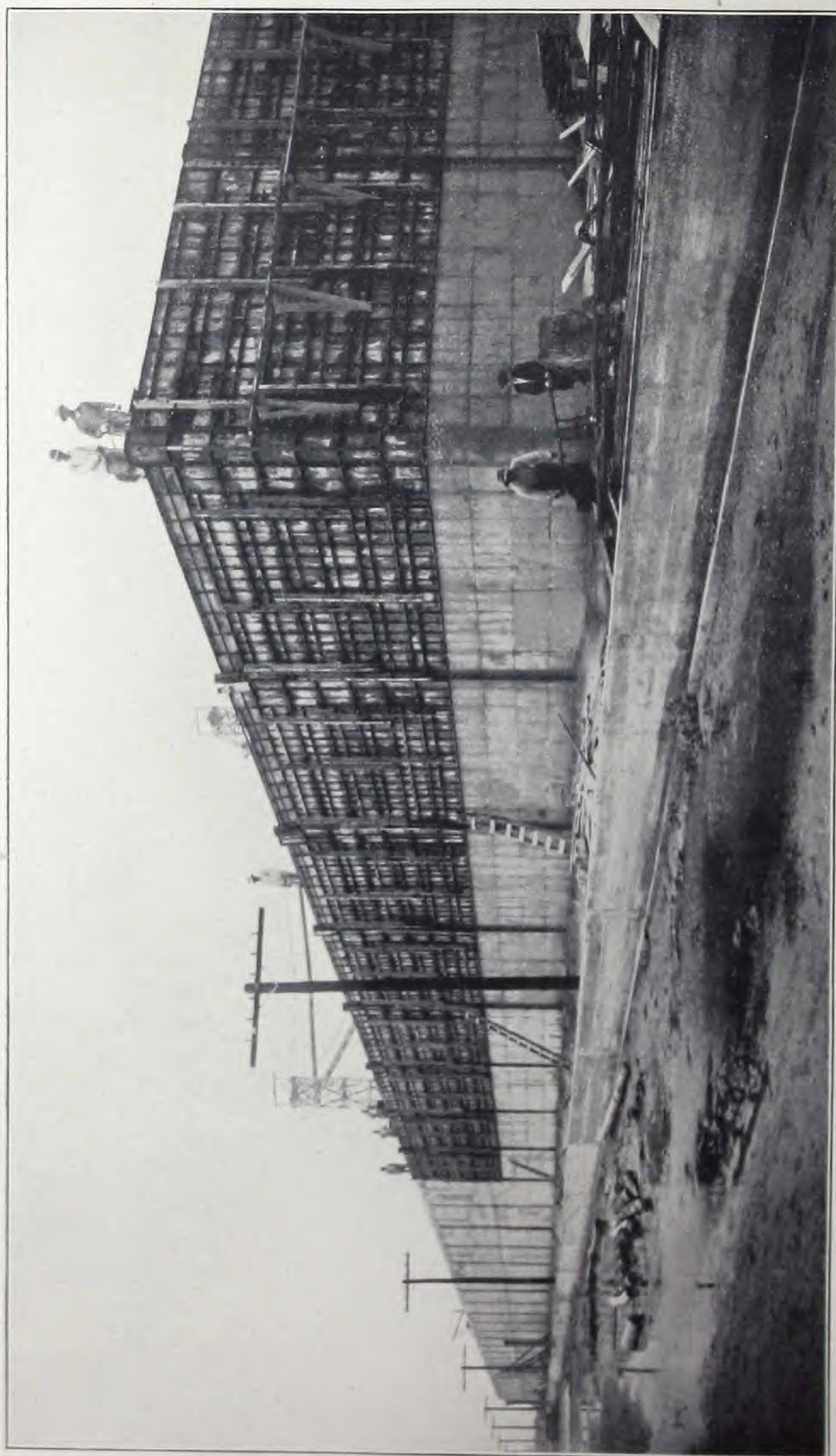
On Page 22 is shown a fire wall for cotton storage in Savannah, Georgia, constructed by Fairbanks, Morse & Co., of Chicago, with Blaw Light Wall Forms.



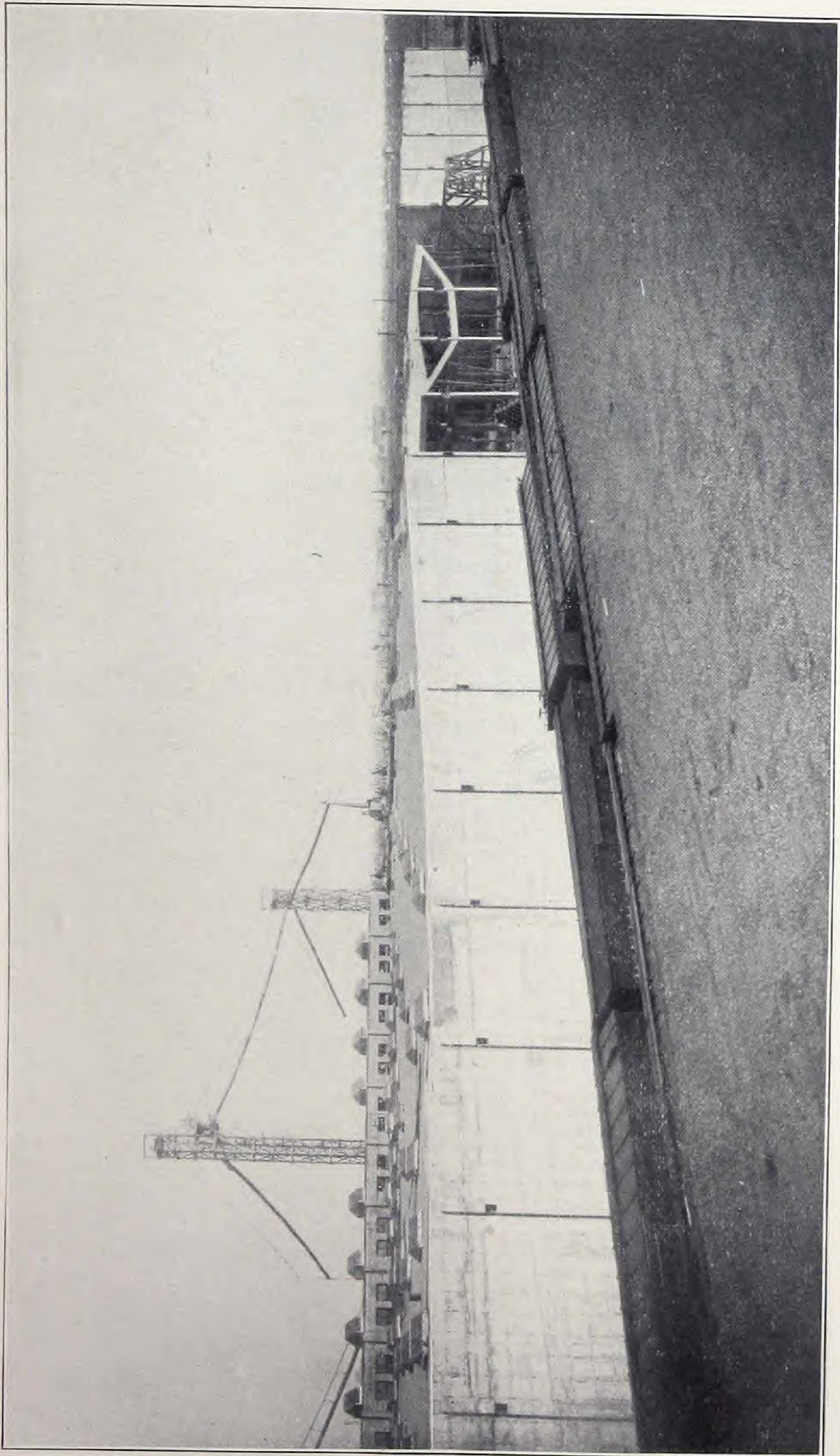
Blaw Light Wall Forms on Walls of Merchants' Compress, Houston, Texas.
James Stewart & Co., Inc., Contractors, St. Louis, Mo.



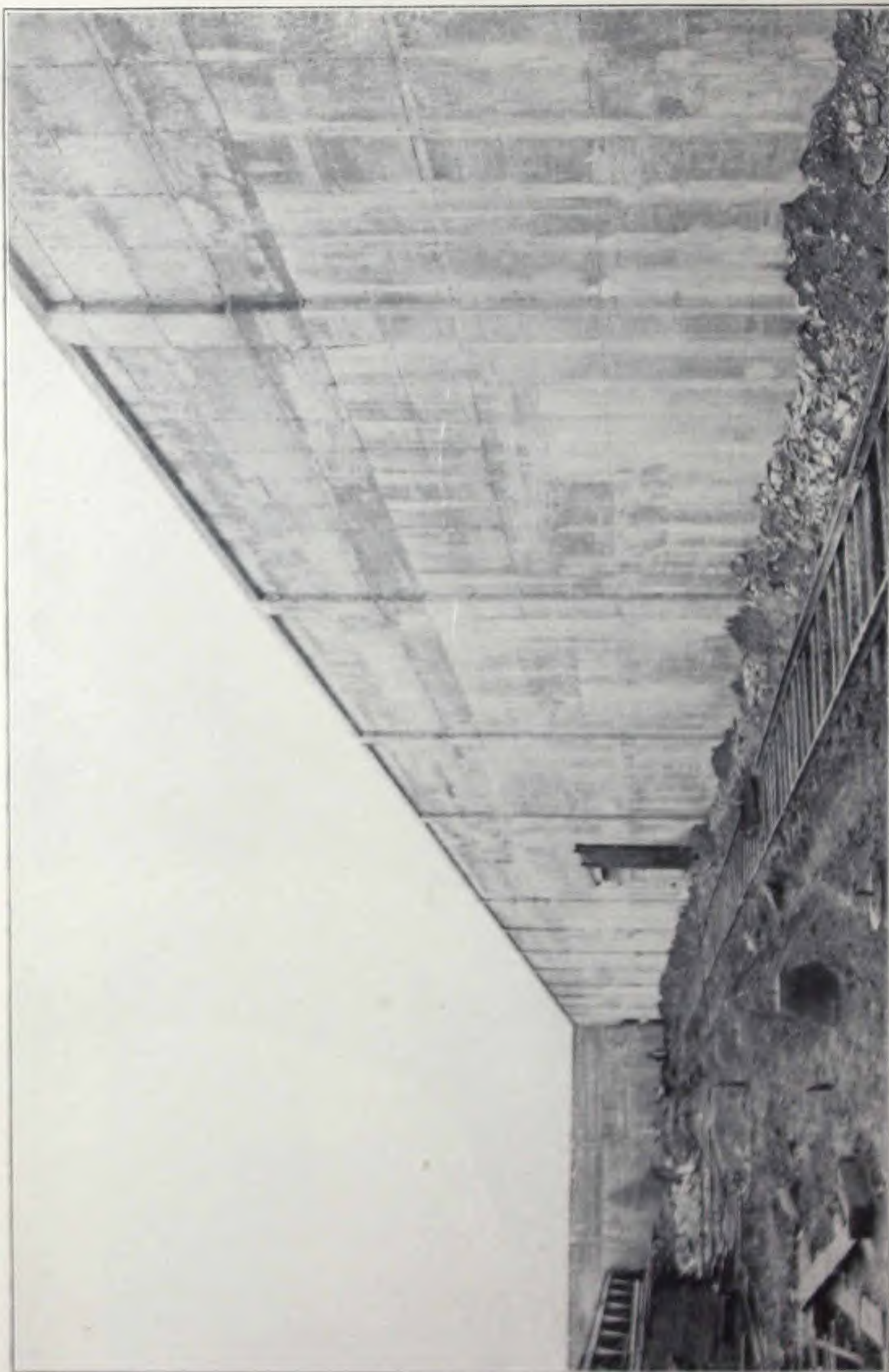
View of completed building, shown on opposite page in course of construction, taken from the roof of adjoining warehouse likewise built by James Stewart & Co., Contractors. Blaw Light Wall Forms used.



Blaw Light Wall Forms in use on Cotton Warehouses for Merchants and
Planters Compress and Warehouse Co., Galveston, Texas.
Gilsonite Construction Co., St. Louis, Mo., Contractors.



View of completed warehouse, shown on opposite page. Taken from
roof of an adjoining building.



View of Fire Wall at Savannah, Georgia. Blaw Light Wall Forms used.
Fairbanks, Morse & Co., Contractors, Chicago, Ill.

INSTRUCTIONS

For Using Blaw Light Wall Forms.

Names of Parts—Plate No. 1 shows the standard panel, with accessories, designated as liner, liner tie, fastener key, and spacer. A wire wall tie and frame for making it are also shown. The use of these parts is shown in diagrams following.

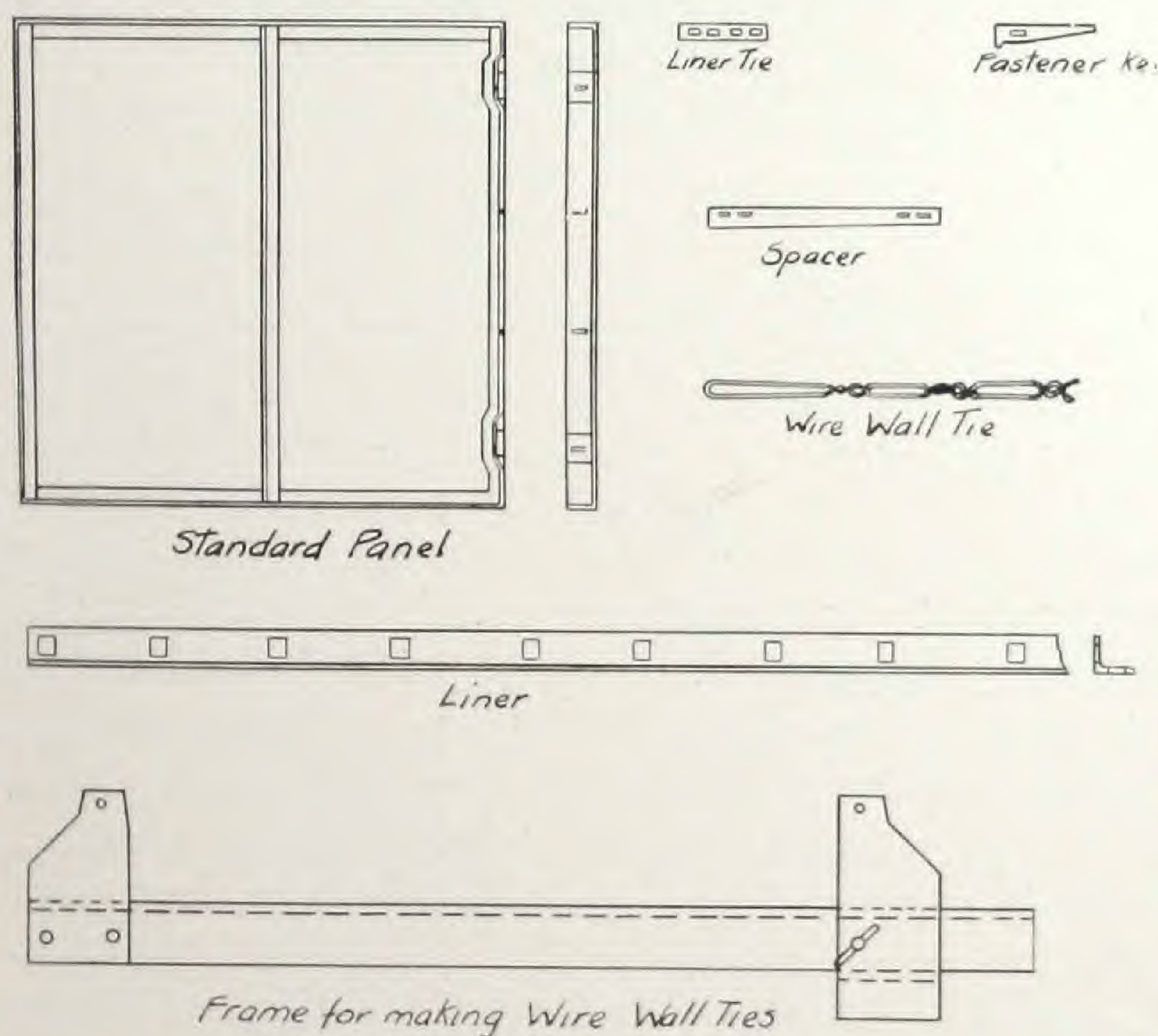


PLATE NO. 1.

Panels—The standard panels are two feet square. They are joined together in horizontal courses two feet wide by the keys, as shown in the elevation on Plate No. 2, Page 24. **Liners** attached by means of liner ties keep the panels in line and make it possible to shift the courses without disconnecting them into separate panels. Either wire ties or steel spacers are used to keep opposing courses from spreading, as the character of the work may require.

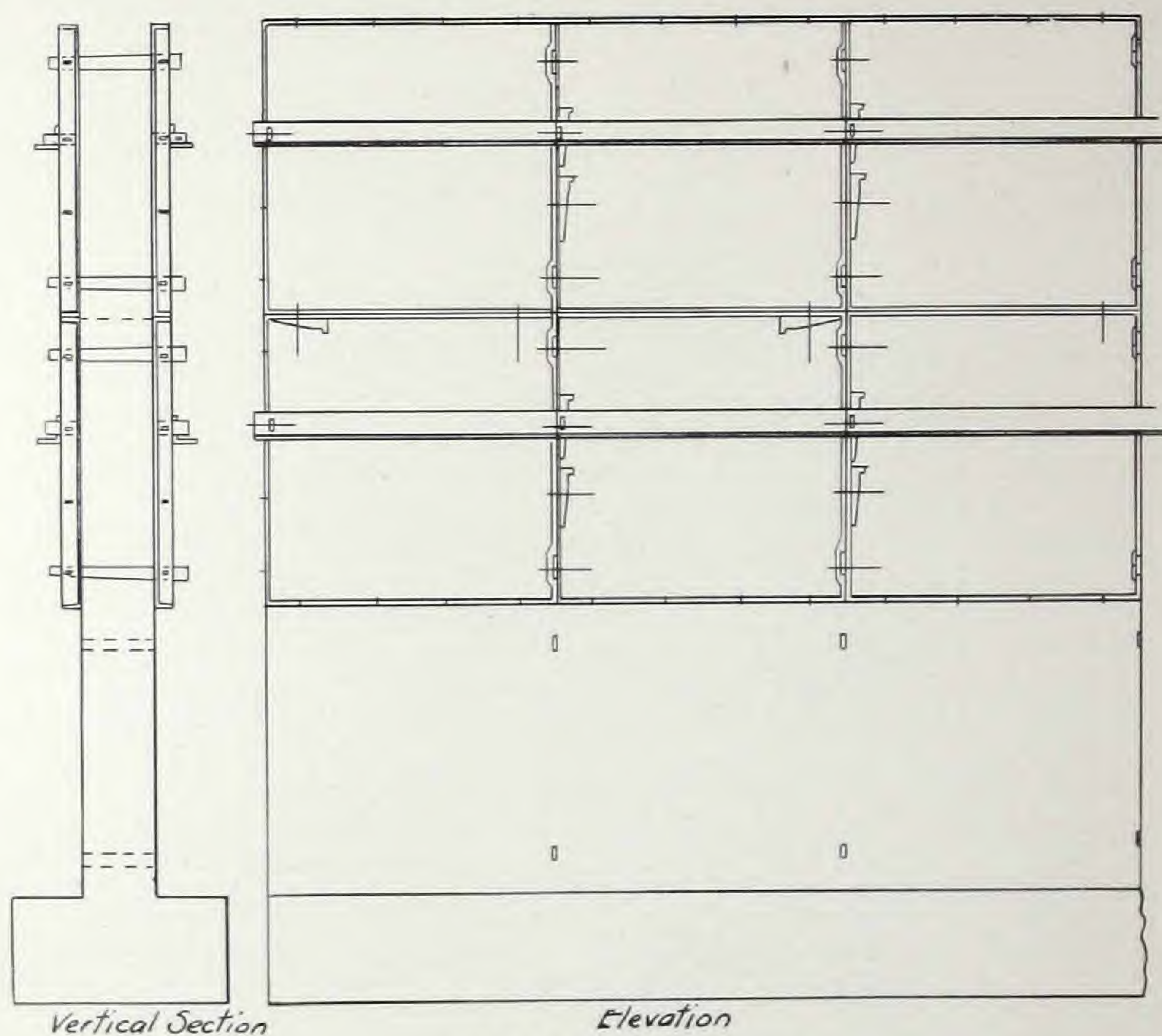
Two-Course Work.

PLATE NO. 2.

The **Cheapest Known Method** of handling forms on walls is known as two-course work. This consists in having two sets or courses of panels, one above the other. When the top course of forms is filled and the concrete has its initial set, the course below is raised, placed on top and filled,—the process being repeated until the wall is carried up the desired height.

On house building and similar work this system is usually followed, and it is worthy of adoption on heavier work in many instances.

Plate No. 2 shows Blaw Light Wall Forms on two course work. The forms, as shown in the vertical section at the left in Plate No. 2, have been filled for a height of two courses (4 feet) and the bottom course raised ready to receive another two feet of concrete. In shifting, the **liners are left attached** to the panels, so that a unit two feet wide and eight, ten, twelve or fourteen feet long is raised at one operation. It is not necessary or desirable to put keys in all of the slots in the joints between the horizontal courses. Use only enough keys in these joints to keep the panels in place.

Wire ties or spacers are inserted after the form is set up; and held by one key through each end, the key passing also through slots in the flanges of the panels.

Strength of Ties—No. 12 annealed iron wire is strong enough for wall ties on two course work, but No. 10 is frequently used on thick walls because it is stiffer.

Spacers—For thin walls standard spacers are a little cheaper to use than wire ties. These spacers should be taken out before the form is removed in order not to damage the wall surface. If not left in more than twenty hours, spacers can be removed without difficulty from walls nine inches thick. Slots left by the removal of spacers should be pointed up as soon as possible after the form has been removed from the wall.

Wherever spacers are used for walls over nine inches thick, or are left in place longer than over night, they should be protected by sheet metal casings, so as to be easily removable, leaving the casings in the wall. We furnish suitable casings where required. We also furnish special spacers, the ends of which may be twisted off, leaving the body in the wall, when these are considered desirable.

Wire Ties—Our wire wall ties are entirely different from the wire ties commonly twisted in place, where other forms are used. Our ties are made up on a frame provided for that purpose, all ties being of equal length and strength before being placed in the form. Consequently all ties are equally strained when concrete is placed in the form, and there is no tendency for the wall to bulge or to get out of line.

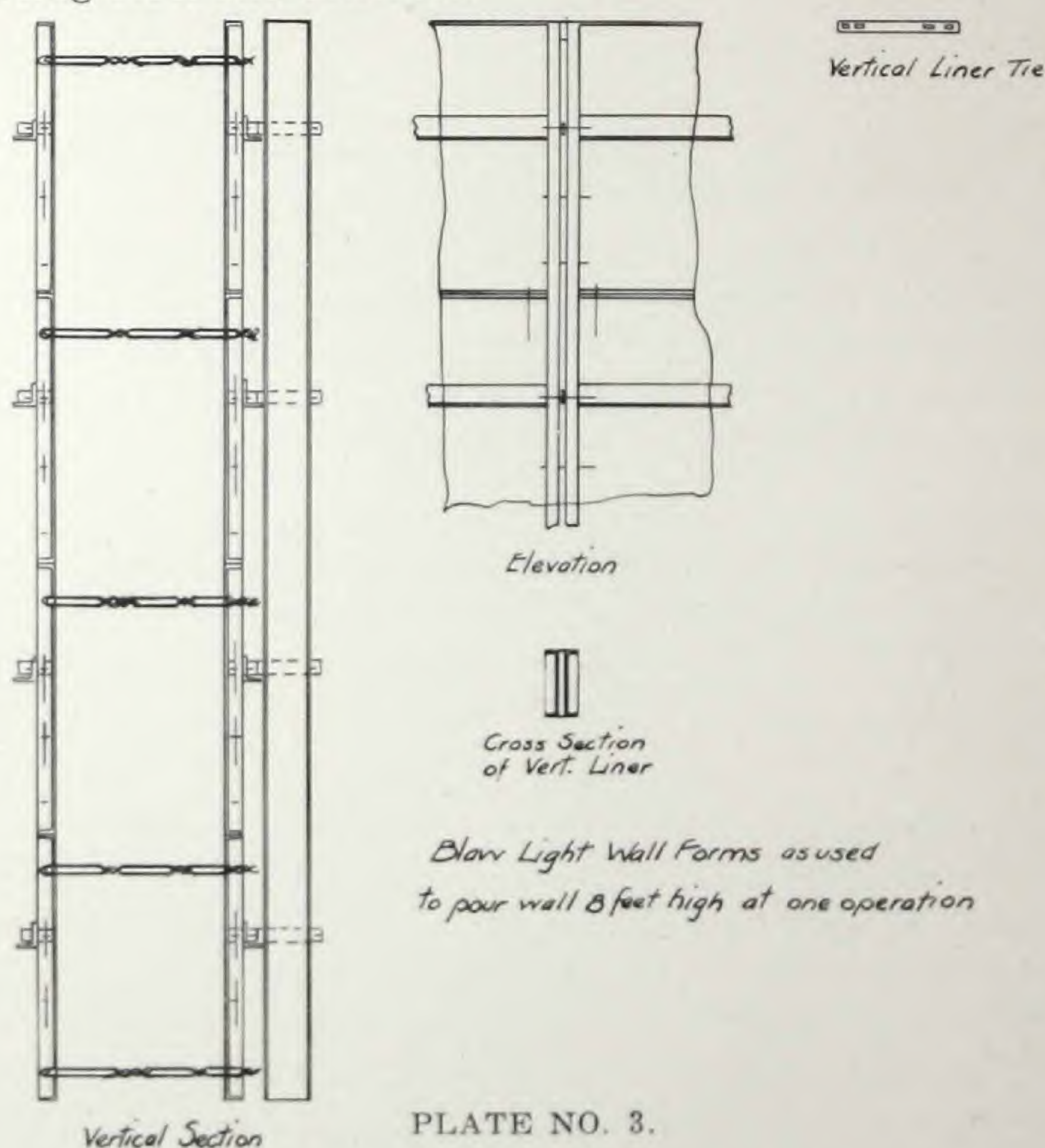
There is also a great saving in labor, as one unskilled man can make up a tie a minute, and place a tie in three seconds. The frame shown in Plate No. 1 for making the ties is adjustable so that it is used to make ties for walls of various thicknesses. After concrete has been placed and forms removed, the projecting loops of the wire ties are usually cut off flush with the surface of the wall; and if a fine finish is required, the ends are bent back into the wall with a chisel or punch, and the depression thus made is pointed up.

We recommend the use of wire ties for all foundations and thick walls.

Daily Progress—By the two-course method six feet of height of wall may be poured the first day, and four feet each succeeding day.

Pouring Several Courses at One Operation.

While the two-course method is the most economical, considered with reference to the forms only, it is not always practicable because of conditions imposed by facilities for placing staging, reinforcing steel and concrete.



Blaw Light Wall Forms, when properly set up, are strong enough to stand the pressure of placing wet concrete in a thick wall to a depth of ten feet in two hours, or to deposit concrete continuously in ordinary building walls at a rate of two feet per hour for ten hours.

Plate No. 3 shows a cross section of form set up for pouring eight feet of wall at one operation. The same arrangement is used for pouring greater heights by merely adding more courses of panels.

In pouring a high wall the form is usually set up for eight to sixteen feet of height and filled. The top course is left in place, and the rest of the form raised and set on top of it, and again filled, the procedure being repeated in lifts of six to twelve feet until the desired height is reached. The vertical liners are removed while the panels are shifted, and replaced later by higher elevation.

The same type of liners as used in horizontal position may be applied vertically, or heavier liners of the type shown on Plate No. 3, may be employed at greater intervals. These heavier vertical liners are furnished in lengths of eight feet. They are very easily attached at any desired elevation.

The panels may be shifted in courses, or in units of several courses, depending upon the facilities provided for handling them.

Strength of Wire Ties—In pouring several courses at one time, it is necessary to put wire ties or spacers in the top and bottom slots of only the **bottom course** and those **courses which remain in place to support the others** when the rest of the form is shifted. One tie per pair of panels is all that is required elsewhere. No. 10 annealed iron wire is strong enough for most work, but No. 8 may be used if desired.

Adjustment for Corners and Intersections.

The foregoing instructions apply to all plain wall work, for which no panels except those of standard size, shown on Plate No. 1, are required. For building construction, corners and intersections must be taken care of, and the forms must also be adjustable as to length.

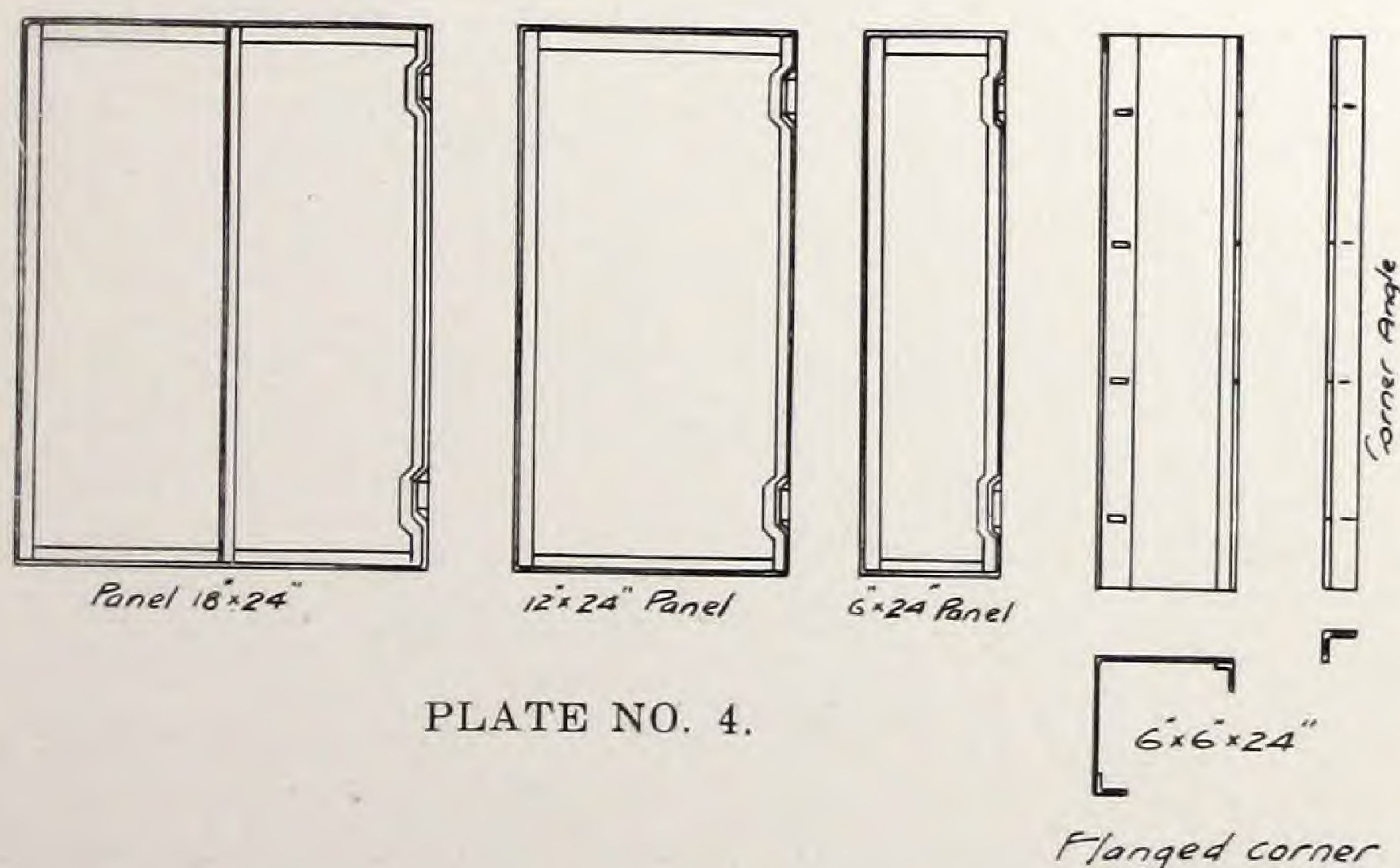


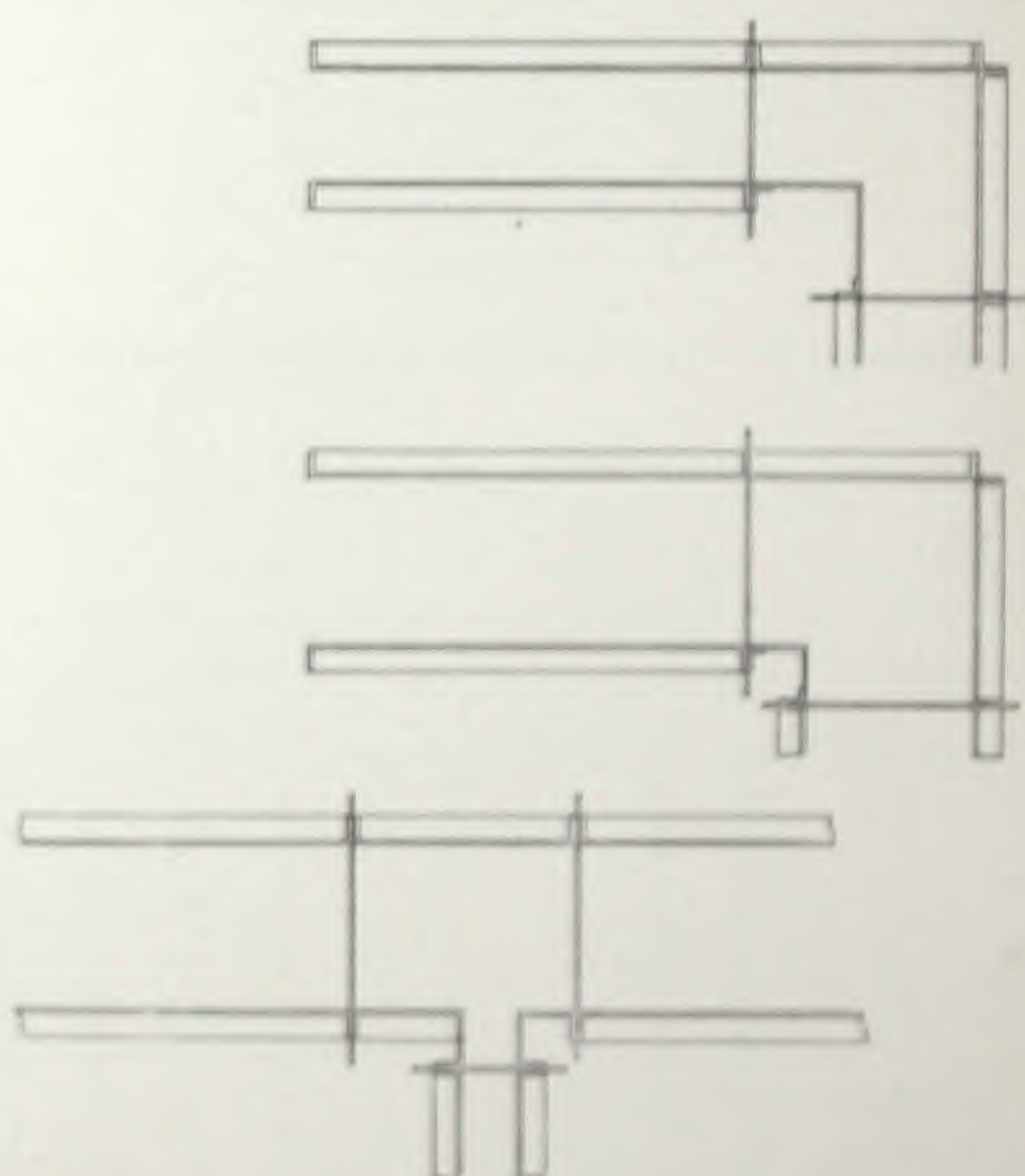
PLATE NO. 4.

Fractional panels, 6 inches, 12 inches and 18 inches wide, shown on Plate No. 4, are used in connection with the standard panels to adjust the length of the wall to within six inches of the required amount.

Lap Panels—as shown on Plate No. 6, take care of any remaining lengths less than six inches. Their use is shown in Plate No. 7.

Flanged Inside Corners—as shown on Plate No. 6 are used if the building walls are of uniform thickness.

For two course work these corners are furnished in two feet lengths, but for multiple course work they may be furnished in any length desired, up to eight feet.

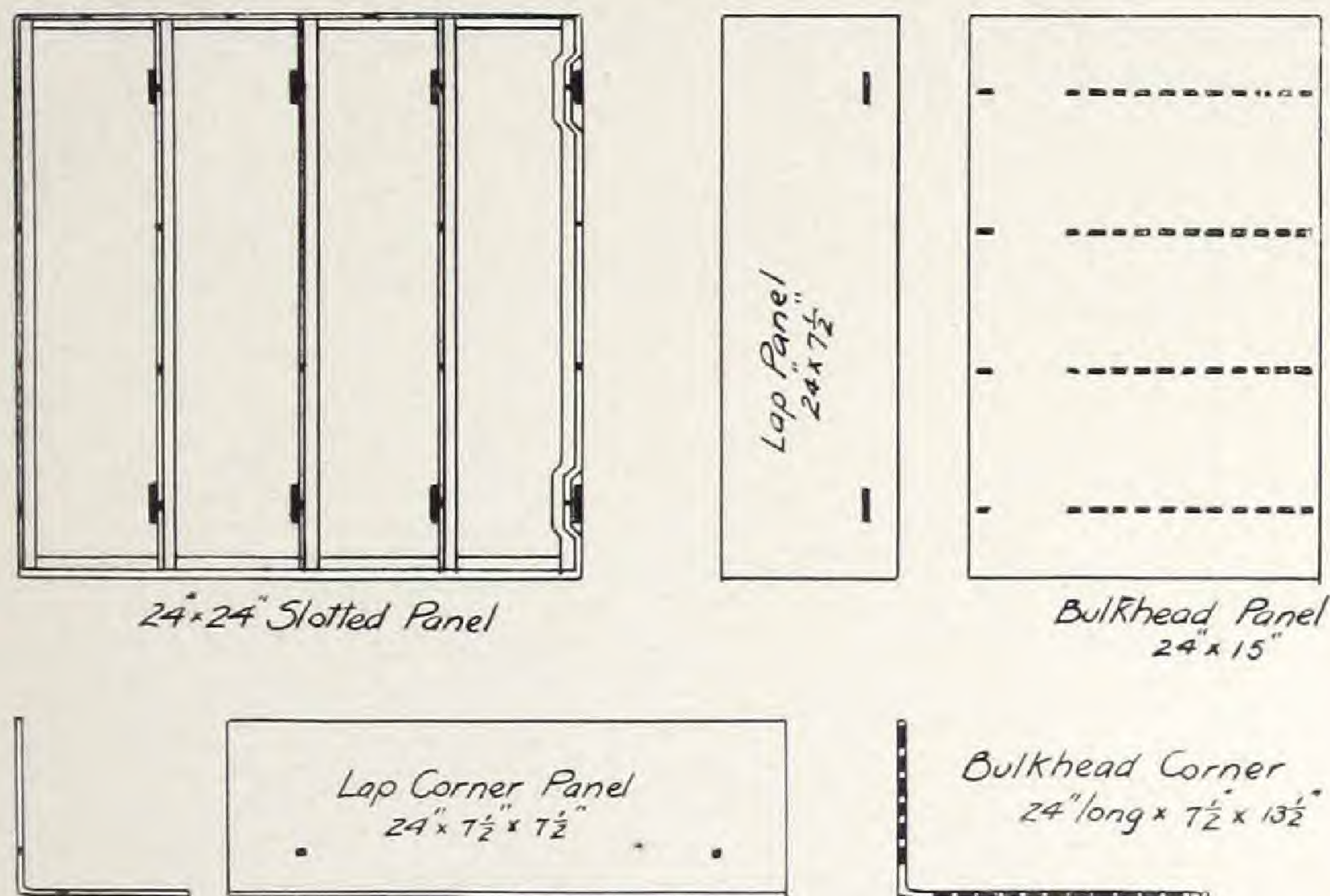


Corners made with flanged corner panels

PLATE NO. 5.

For work on which walls vary in thickness, such as miscellaneous foundations, and for some other purposes, it is desirable to use lap sheets, of which there are four standard types, as shown on Plate No. 6, with the slotted panel of standard dimensions.

Lap Corners and Bulkhead Corners—may be used for wall corners and intersections, as shown in Plates No. 7 and No. 8.



*Panels used in adjusting length
and turning corners.*

PLATE NO. 6.

The lap corners are used, ordinarily, on the inside of the wall only, corner angles being employed on the outside. The slotted panels are used to provide surfaces against which the lap panels may rest, without having to be perforated to allow spacers to pass.

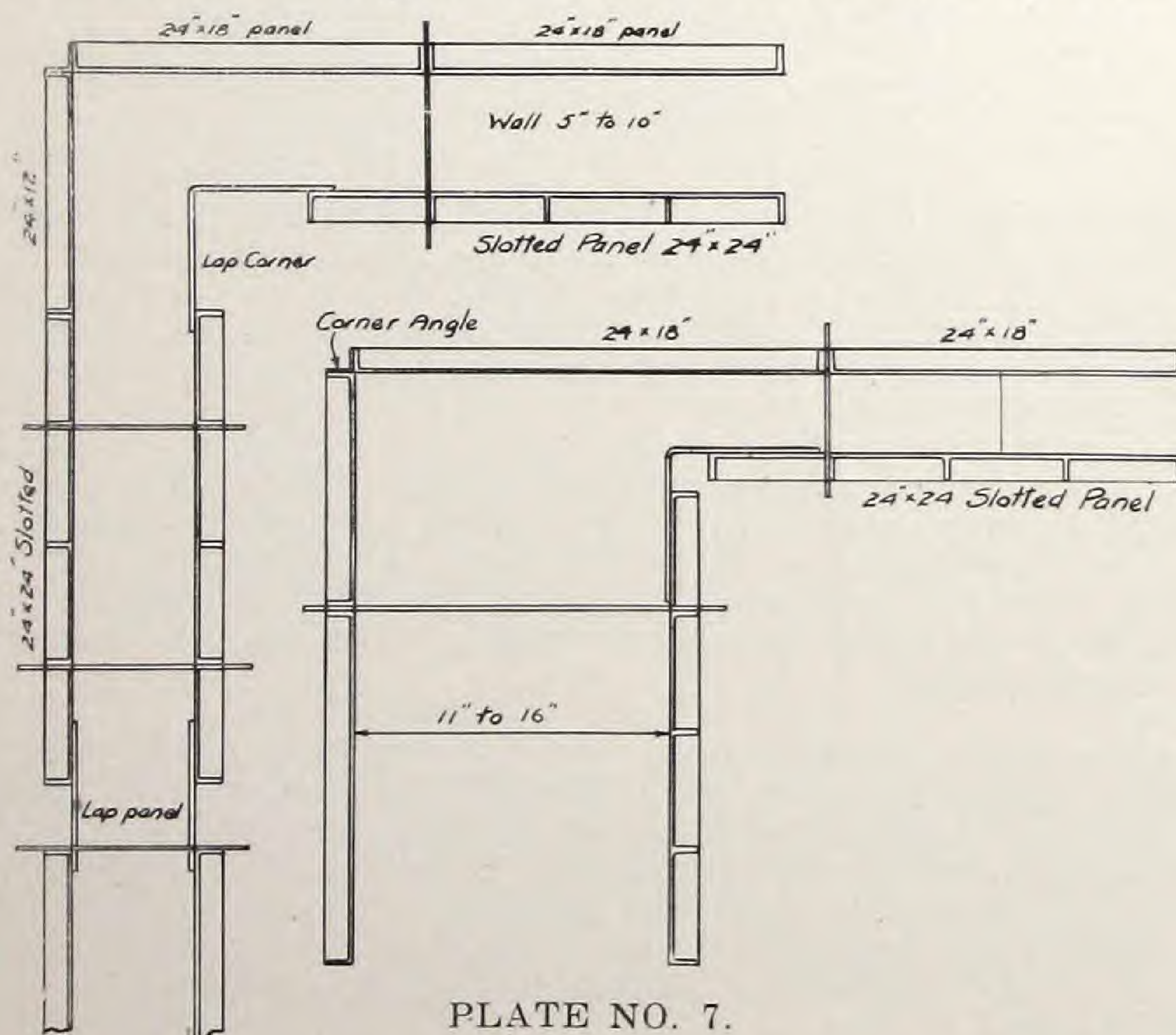


PLATE NO. 7.

Lap corners are not fastened to the panels against which they rest. On two-course work no fastening is necessary; but if a fastening is desired, the lap corners may be wired as shown in the diagram on Plate No. 8.

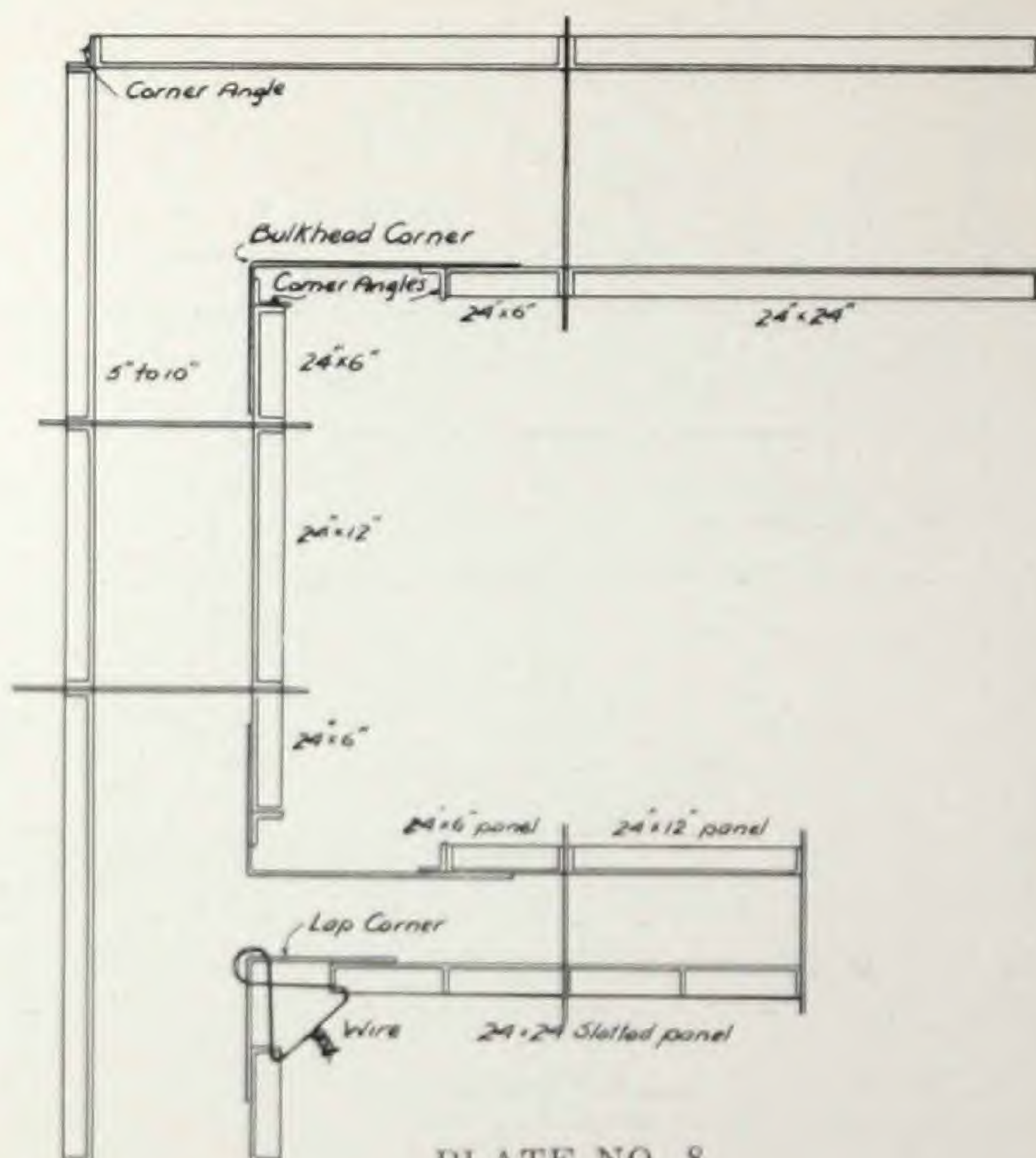


PLATE NO. 8.

Bulkhead corners may be used instead of lap corners, as shown in Plate No. 8. They are attached to the adjoining panels by means of corner angles. This arrangement is more rigid than by the use of lap corners but it requires more fastenings. Bulkhead panels and bulkhead corners are especially useful in making offsets in walls, for pilasters or chimneys, or for closing the end of a wall.

Many other uses of these panels will suggest themselves to the builder when he has become familiar with the forms. The corner panels may be spread out to other angles than 90° for use in bay windows; and they may be used on the outside as well as the inside of walls if desired. Occasionally it is desirable to use some tie wire to hold together panels when employed in an unusual manner.

Specials—While standard parts may be used to build structures of any ordinary design, it is frequently possible by the use of specials for pilasters and belt courses on large contracts where the same detail is many times repeated, to make a saving in the cost of handling. On very large jobs, therefore, we solicit our patrons to submit us the plans, and to let us submit recommendations as to the most economical method of handling the forms under the conditions imposed. For such service we make no charge.

The Blaw System a Success.

A striking proof of the success of Blaw Steel Forms is shown by the selection of Blawforms for use in building the Panama Canal, the Catskill Aqueduct, the New York Subway System, the Winnipeg Aqueduct, a number of important Government contracts, and hundreds of building, sewer, wall, paving and bridge contracts.

Blawforms are designed and built for every type of Concrete Construction. Whether you build Sewers, Aqueducts, Drains, Subways, Tunnels, Shafts, Viaducts, Bridges, Piers, Caissons, Locks, Dams, Manholes, Retaining Walls, Reservoirs, Houses, Warehouses, Factories, Foundations, Floors, Walls, Columns, Beams, Girders, Silos, Tanks, Grain Bins, Sidewalks, Curbs and Gutters, Integral Curb and Road Construction, Blawforms will save money for you.

In the list of publications shown below, you get an idea of the varied uses to which Blawforms can be put. Copies of any of these publications will be gladly sent on request.

Blaw Publications.

- Catalog 8**—Concrete Sewer Construction.
- Catalog 10**—Steel Centering for Concrete Construction.
- Catalog 12**—Steel Forms for General Concrete Construction.
- Catalog 14**—Blawforms.—General Catalogue.
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A Word With Reference to Blaw Patents.

Blawforms in all their various types are covered by a large number of patents, issued and pending. For the past ten years our large corps of Engineers and Experts have specialized on this work to the extent that the Blaw Company are now known throughout the civilized world as the Form Experts in all classes of Concrete work.

In the development of these patents we have spent considerable sums, and we are prepared, in self-protection, to prosecute vigorously any and all attempted infringements.